

PCT/NZ2004/000254

REC'D 17 NOV 2004

WIPO PCT

CERTIFICATE

This certificate is issued in support of an application for Patent registration in a country outside New Zealand pursuant to the Patents Act 1953 and the Regulations thereunder.

I hereby certify that annexed is a true copy of the Provisional Specification as filed on 16 October 2003 with an application for Letters Patent number 528981 made by ANDREW LEO HAYNES.

Dated 8 November 2004.

PRIORITY DOCUMENT
SUBMITTED OR TRANSMITTED IN
COMPLIANCE WITH
RULE 17.1(a) OR (b)

BEST AVAILABLE COPY



Neville Harris
Commissioner of Patents, Trade Marks and Designs



NEW ZEALAND
PATENTS ACT, 1953

PROVISIONAL SPECIFICATION

CLADDING SYSTEM

I, ANDREW LEO HAYNES, a New Zealand Citizen of 3/7 Mably Court, Stanmore Bay, Whangaparaoa, New Zealand, do hereby declare this invention to be described in the following statement:

Intellectual Property
Office of NZ

16 OCT 2003

RECEIVED.

The field of the present invention relates to claddings systems for buildings or structures, particularly a cladding system relating to sealing a building or structure optionally with an in place continuous weatherproof membrane.

For the weather proofing of a building, in particular the roof (but also applicable to side wall on other surface cladding), there are many systems available.

For roofs these extend to tiles and other discreet forms of layered roofing protection such as long run steel and corrugated roofing. For walls there are similar type cladding systems of discreet tiles or sections to cover and seal the wall. Another class of cladding systems both for roofs and walls is to utilise a semi-continuous membrane which is laid, coated or otherwise applied to the surface to be sealed and which may be in-place sealed to form a continuous membrane, e.g. sheets which are layed down and then sealed to each other at their periphery.

Methods of doing this presently involve the laying of such a membrane onto a substrate and attaching the membrane directly to the substrate by gluing or adhesive means. This therefore requires the application or adhesive or adherent means to the substrate and then subsequent application of the cladding sheet or material and/or any fixings to hold the cladding in place while the adherent or adhesive cures. This is particularly time consuming and involved, especially when on the side of a building, for example. There are also roofing systems that relay upon ballasted means to retain the roofing or cladding system in place. For example the laying down of a semi-continuous membrane and rather than adhering this to the base structure a grit or stone course material is layed over the top and by the weight of this material the cladding is retained on the roof structure. Over time however such ballasted roofings can break down the membrane on which they lie. Such cladding systems thus whilst easy to lay, have an ongoing maintenance issue.

The further short coming of such present membrane cladding systems for weather proofing buildings and/or structures is their exposure to the elements and particularly ultra violet light. Such constant exposure to ultra violet light ultimately breaks down the majority of materials that have been used to date for such membrane cladding systems. It is also desirable to have a material which is resistant to the

elements which can also be formed into position whilst still imparting a membrane like structure or coating.

An advantage therefore is to be gained by the use of material which is long term stable (i.e. 50 years or more) in the presence of ultra violet light in such a building structure cladding system. A further advantage is to be gained when such a cladding membrane is available for simple and fast fastening and installation.

It is therefore an object of the present invention to provide a membrane cladding system for buildings, structures or the like which at least goes some way to overcoming at least some of the above disadvantages or at least goes some way to meeting the above desiderata and/or provides the public with a useful choice.

In a first aspect the present invention consists in a **building cladding system** to be applied to a cladding substrate, said cladding system having a cladding material of fusible material which is at least in part attached or attachable by fusing said to fastenings, said fastenings at least penetrating said cladding substrate,

wherein by further fusion to itself said cladding material forms a generally continuous membrane over said cladding substrate.

Preferably said fusion is by fusible welding such as thermal or ultrasonic welding.

Preferably said fastenings have a layer of material fusible to said cladding material on that surface which presents to said cladding material.

Preferably said fusible material is a thermoplastic polyurethane.

Preferably said fastenings sit on top of said cladding and have said material fusible on their underside.

Alternatively said fastenings sit intermediate said cladding material and said cladding substrate and have said material fusible on their top side.

In other embodiments the fastenings may sit within the structure of the cladding membrane.

Preferably said fastenings may join, by fusible welding, adjacent sheets of cladding membrane.

Preferably said fastenings are of an elongate strip form.

Alternatively said fastenings are of a discrete or washer like form.

Preferably said fastenings are rigid core with said fusible material coated thereon.

Alternatively said fastenings are a singular material of fusably weldable nature.

Preferably said fastenings are penetratively fixed to at least said cladding substrate.

Preferably said fastenings have provision for or can be associated with a penetrative fastener.

In a second aspect the present invention consists in a **cladding membrane system** for a building structure said cladding membrane having at least a first layer with an external major surface of a ultraviolet stable heat or sonic fusible thermoplastic polyurethane, said cladding membrane fusible to itself to form at least an in part continuous weather proof cladding for said building structure.

Preferably said thermoplastic polyurethane has a secondary lamination to its internal major surface of one of the following:

- i) Acrylonitrile – Butadiene – Styrene (“ABS”), or
- ii) Aluminium foil/or sheet
- iii) Aluminium mesh (or expandable aluminium), or
- iv) Polypropylene (“PP”), or
- v) Polyethylene (“PE”), or
- vi) Thermoplastic polyurethane (“TPU”), or
- vii) Natural fibre or cloth (eg jute or cotton), or
- viii) Man made fibre (eg PP, polyethylene terephthalate (“PET”), PE in woven, non-woven melt blown or filament form)
- ix) a plastics material, or
- x) a metal material.

Preferably said cladding membrane may have a further tertiary lamination to the underside of said secondary lamination of one of the following:

- i) Thermoplastic polyurethane (“TPU”), or

- ii) Acrylonitrile – Butadiene – Styrene (“ABS”), or
- iii) Polypropylene (“PP”), or
- iv) Polyethylene (“PE”), or
- v) Polyethylene terephthalate (“PET”), or
- vi) Ethylene Propylene Diene Monomer (“EPDM”), or
- vii) Ethyl Vinyl Acetate (“EVA”), or
- viii) a plastics material, or
- ix) a metallic material.

Preferably where there is a secondary and tertiary layer the secondary layer lies between said first layer and said tertiary layer.

Preferably said secondary layer is encapsulated by said first and tertiary layers.

In another aspect the invention consists in a **method of rendering at least part of a building envelope** with a weatherproof membrane, said method comprising or including the steps of

- i) providing an array of fixing members, attaching into part of the structure of the building envelope,
- ii) prior to and/or subsequent to the attaching of at least some if not all of said array of fixing members locating a membrane to define a weather resistant surface, erectable whether or not said membrane is of a single composition, fabricated as a laminate structure or otherwise, and

selectively fusing and/or moulding material(s) of said membrane and material(s) at least in part of said array of fixing members to each other by application in situ of ultrasonic or heat or other method causing at least in part fusion of said membrane to some or all of said fixing members.

In some embodiments said membrane may be fused to itself to form a join or fold to itself or adjacent membranes.

Preferably there is also an array of adjacent sheets of material by fusible welding.

In one option the membrane includes at least in part a thermoplastic polyurethane and preferably where said thermoplastic polyurethane is not itself coated it is rendered resistant to UV radiation if required.

In some forms of the present invention the array of fixing members is pre-attached to said structure of the envelope prior to over lying thereof with the membrane and subsequent fusing thereto. In other forms of the present invention the attaching of the array of fixing members involves a penetration of the already layered membrane and subsequent attaching to said structure, and fusible welding to said membrane.

In some forms of the present invention each **fixing member** to provide the array includes provision of a member of substantially planar form with at least a layer of TPU on that surface to be fusably associated with said cladding membrane, having at least one penetrative fastening protruding from its under side for penetrative association with a building substrate or structure.

Preferably said fixing members are discrete "washer style" planar forms with one penetrative fastening there on.

Preferably said fixing members are circular in platform. Alternatively they are of many sided polygonal shape in platform.

Alternatively said fixing members are elongate "strip style" planar forms having a multitude of penetrative fastenings arranged along their length.

In some embodiments the fixing members may have a ridge running their length to form a T joint between abutting sheets of cladding membrane.

In yet further embodiments still, in cross-section the fixing member may have a cap like portion extending outwards from an upright to provide a cap that abutting sheets of cladding membrane may at least in part lie under to form a join and/or fastening down of the cladding membrane.

Preferably said cap may be one sided to receive only one sheet of cladding membrane.

Alternatively said cap is two sided to receive two sheets, one either side of said upright, of said cladding membrane.

In yet another form still said fixing members may lie on top of said laid cladding membrane, penetrating said membrane and fastening down to said building substrate.

Alternatively said fixing members may lie underneath said cladding membrane before said membrane is laid.

Preferably once said fixing members are fastened in place (either above or below said cladding membrane) and said cladding membrane is laid, the fixing member and membrane are at least in part fusably welded to each other to at least fasten said membrane down.

Preferably if said fixing member is above said cladding membrane said fusible welding also seals at least in part underside periphery of said fixing member to said cladding membrane.

Preferably said fixing member has at least in part a lining of fusably weldable material on its under side when fastening said cladding membrane from above, to fusably weld to the fusably weldable upper layer of the cladding membrane.

Alternatively said fixing member has at least in part a lining of fusably weldable material on its underside when fastening said cladding membrane from below, to fusably weld to the fusably weldable material lower layer of the cladding member.

Preferably said fusably weldable material on said fixing members is a thermoplastic polyurethane.

Preferably said fusably weldable material on said cladding membrane is a thermoplastic polyurethane.

Preferably said fixing members have a core of material and consist of a core of material with said thermoplastic polyurethane laminated there over.

Alternatively said fixing member may consist only of said thermoplastic polyurethane.

Preferably said penetrative fastening is fixed to or passes through said core.

Preferably said fixing member presents a sealed or sealable upper surface.

Optionally a further sealing member may be added to or over said fixing member so that when said fixing member is fusably welded to said cladding membrane a weather and element proof upper surface is presented.

Such fixing elements may be used in corners, slope and/or cladding, ridgelines, changes in shape and/or curvature to fasten and/or seal abutting or continuous cladding membranes.

In a further aspect of the invention consists in a structure rendered at least in part waterproof by the use of a method in accordance with the present invention.

In yet a further aspect the present invention consists in, in combination, a plurality of said fixing members and a membrane compatible therewith so as to be complimentary therewith if used in a method in accordance with the present invention.

In yet a further aspect the present invention consists in a roof, wall or other region of a building envelope rendered weather resistant by use of a membrane of any of the kinds herein exemplified where such membrane is held in place by localised association with each of an array of fixing members,

wherein said association optionally includes moulding or fusing of a thermoplastic polyurethane with a complimentary material forming at least part of each said fixing members.

In still a further aspect the present invention consists in a fixing member suitable for use in a method in accordance with the present invention.

This invention may also be said broadly to consist in the parts, elements and features referred to or indicated in the specification of the application, individually or collectively, and any or all combinations of any two or more of said parts, elements or features, and where specific integers are mentioned herein which have known equivalents in the art to which this invention relates, such known equivalents are deemed to be incorporated herein as if individually set forth.

Preferred embodiments in accordance with the present invention will now be described where:

Figure 1 shows a plan and side elevation of a fixing member to lie over the top of said cladding membrane,

Figure 2A shows a square form of the fixing member of Figure 1 and Figure 2B shows a penetrative fastening which is used to fix the fixing member down onto the cladding membrane penetrative the cladding membrane and attaching to the envelope or building structure underneath,

Figure 3 shows a plan and side elevation of a fixing member to lie underneath the cladding membrane for the cladding membrane to be fusably welded to,

Figure 4A shows a square form cladded elevation of fixing members similar to that of Figure 3 and Figure 4B shows a penetrative fastener to fasten the fixing member to the building envelope or substrate,

Figure 5 shows a jointer for two abutting membranes to deform a tee joint, the jointer to lie over the top on the external surface of the cladding membrane, the joint is shown in cross-section being an extrusion, with optional fusible protrusions on its underside,

Figure 6 shows a further form of jointer, which is shown in cross-section, of an extrusion and has a joining part layed down over the top of the joint of two abutting membranes whereby a penetrative fastener passes through the jointer, a cap is laid on top of that and the jointer is fusably welded to the two membranes underneath to form a weatherproof joint, shown with optional fusible protrusions on its undersides,

Figure 7 shows in cross-section an extrusion of a jointer similar to that of Figure 5 but of greater width to be fusably welded to the external surface of two abutting membranes, shown with optional fusible protrusions on its undersides,

Figure 8 shows in plan and in cross-section a jointer which is to be fastened by penetrative fastenings staggered along the length and width of the jointer through the jointer into the envelope or building structure, the cladding membranes then layed over the top to abut the tee portion of the jointer and thereafter fusably welded to the jointer to form a weather proof joint, shown with optional fusible protrusions on its undersides,

Figure 9 shows in plan and in cross-section a further form for a jointer which has a cap for location of the membrane to be jointed, the jointer layed onto the building structure or envelope and penetratively fastened thereto and thereafter the

membranes to be jointed are laid onto the jointer under the cap and fusably welded to form a weather proof seal,

Figure 10 shows a similar joint to the of Figure 9 but with provision for fastenings through the sides and the middle,

Figure 11 shows the jointer of Figures 9 and/or 10 attached to the building substrate by a penetrative fasteners, the cladding membrane then layed onto the jointer and passed under the cap and thereafter fusably welded to form a weather proof joint,

Figure 12 shows a corner fixing member similar to that shown in Figure 1 with the exception that it is cone shaped (to be shown later) whether flexible or rigid having penetrative fastenings passing at least in part through the fixing member and through the membrane to be fixed in the corner and thereafter the fixing member fusably welded to the cladding membrane to thus seal the corner and also hold the cladding membrane in place, the same component with reversed fastenings could be used on a ridge corner,

Figure 13 shows a similar view to that of Figure 12 with the exception that the fixed member lies underneath the cladding membrane is penetratively fastened to the building substructure and thereafter the cladding membrane is fusably welded to the fixing member, again the member may be flexible or rigid and may equally be used on a ridge corner with fastenings reversed.

Figure 14 shows an assembly of the cladding membrane fastened by either over or under fixing members shown in Figures 1, 2, 3 and 4 to locate the cladding membrane onto the building substrate and also shows a strip jointer or fixing as shown in any one of Figures 6, 8, 9, 10 or 11 and also a corner jointing member which has penetrative fastenings at least in part through itself and also through the cladding membrane to be held and thereafter the fixing member is fusably welded to the membrane underneath thus forming a weather tight corner seal and also holding the membrane in place, the same member can equally be used on a ridge with reversed fastenings,

Figure 15 is a similar view to that of Figure 14 showing another embodiment of the corner fixing member, again being able to be used on a ridge with reversed fastenings,

Figure 16 is a similar view to that of Figure 15 however the fixing member lies underneath the cladding member, is penetratively fixed to the building substructure and thereafter the cladding membrane is fusably welded to the fixing member to form a weather proof seal and also hold the cladding membrane in place,

Figure 17 shows in cross-section and plan a fixing member for fixing and or sealing the cladding membrane in a corner situation,

Figure 18 shows a similar set of views to that of Figure 17 with the exception that the fixing member is of T shape for use in a corner and extension situation,

Figure 19 shows in side elevation and cross-section a strap like fixing member for external mounting over the cladding membrane with penetrative fastenings at least in part through the fixing member down through the cladding membrane which is thereafter fusably welded to the cladding membrane to hold the cladding membrane in place, this fixing member may be used to seal a joint or merely to hold the cladding membrane in place,

Figure 20 shows a similar view of a strap like fixing member to that of Figure 19 with the exception that the fixing member lays underneath and fastened to the buildings substructure with the cladding member layed over the top and thereafter fusably welded to the fixing member,

Figure 21 A, B, C and D show various forms of a rigid corner member for sealing a corner of three surfaces to form a weatherproof corner seal,

Figure 22 A through D shows various views of a circular corner jointer which is rigid which may be deformable under heat or cold forming to seal a corner or a circular corner of the cladding membrane,

Figure 23 A through D shows various views of a further external rigid corner sealer similar to that shown of Figure 21,

Figure 24 views A through D shows a similar circular sealing member to that of Figure 22 which the exception that it is flexible and has a different embodiment of cone structure for sealing a corner,

Figure 25 A through D shows another variant of that of Figure 24 being a flexible corner sealer of differing angle again,

Figure 26 A and B shows a building substructure to which the cladding membrane has been attached and the various means by which the cladding membrane is attached to the substructure, and

Figure 27 shows in cross-section at (i) a two layer lamination consisting of A being the external layer and B being the second layer and at (ii) shows a three layer configuration of A external, B secondary and C tertiary layers and then at (iii) a three layer lamination consisting of A, B, C whereby B is encapsulated between A and C a single layer construction though not shown is also contemplated.

The form of the cladding membrane for a building system and its various layups is summarised in Table 1 from the first layer being the top layer exposed to the environment the second layer and/or third optional layer successively. Figures 27(i), (ii) and (iii) show the options for layup being a two layup system consisting of a first layer 1 (also denoted by A in the accompanying table) the second layer laminated to the first layer 2 (also denoted by B in the accompanying table) and if used a third layer indicated by 3 (and also C in the accompanying table). The first layer which is exposed to the environment consists of a layer of thermoplastic polyurethane of between 0.01mm to 1.5mm in thickness. This may be the only layer present for some embodiments however other embodiments go on to have second and optionally third laminates to the top layer. A second laminate 2 (or B) may consist of an acrylonitrile butadiene styrene (ABS) of thickness between 0.001mm to 2.5mm. This may be the only other layer attached to the first layer although optionally there is a third layer that can be attached to a TPU-ABS layup being a further layer or third layer 3 (or C) of TPU of thickness between 0.01mm to 2.5mm, or an ABS layer of between 0.01mm to 2.5mm. When using a three layer laminate the middle layer 2 (or B) may be either continuous with the first 1 and third 3 layers or may be encapsulated by these two

layers by sealing at the periphery of the sheet of cladding membrane to fully or partially encapsulate the second layer 2.

A differing second layer may be used consisting of aluminium foil or aluminium mesh whether partially or fully expanded or able to be expanded of thickness between 0.001mm to 2.5mm. In such a layup an optional third layer 3 may be of ABS or TPU or PP or PE or EPDM or EVA varying between 0.01mm to 2.5mm. A similar situation exists where the second layer of aluminium foil or expandable aluminium mesh may be continuously laminated with the first and third layers or may be encapsulated therein as above.

The second layer 2 may alternatively consist of a layer of polypropylene of between 0.001mm to 2.5mm and thereafter may have a third optional layer 3 laminated therewith consisting of ABS or TPU or PP or PE or EPDM or EVA of a thickness between 0.01mm to 2.5mm. Again the second layer 2 of polypropylene may be fully laminar or encapsulated.

The second layer alternatively may consist of polyethylene between 0.001mm to 2.5mm and again may have an optional third layer of ABS or TPU or PP or PE or EPDM or EVA of thickness between 0.01mm to 2.5mm laminated to form a three layer structure. Again the second layer 2 of polyethylene may be fully laminar or encapsulated by the first layer of TPU and the subsequent third layer.

The second layer again may alternatively consist of natural fibres or cloth such as jute, cotton or other naturally occurring fibres of between 0.001mm to 2.5mm laminated to a top layer 1 of thermoplastic polyurethane. Optionally a third layer may be laminated thereto consisting of ABS or TPU or PP or PE or EPDM or EVA or TPR or PET of a thickness between 0.01mm to 2.5mm. Again the second layer of natural fibre may be fully laminar or encapsulated by the first and third layers.

The second layer again may alternatively consist of a manmade fibre such as but not limited to PP or PET or PE of a thickness between 0.001mm to 2.5mm which may be of woven, non-woven melt blown or filament form. Optionally a third layer may thus be laminated to the second layer consisting of ABS or TPU or PP or PE or EPD or EVA or TPR or PET of a thickness between 0.01mm to 2.5mm. Again layer 2

manmade fibre may be fully laminar or encapsulated by layers 1 and 3. Other lay ups of differing plastics or metallic materials are contemplated (whether of multiple laminates or not) and these combinations fall within the scope of the invention.

Other lay ups may incorporate a mastic or adhesive or adhesive enabling or easily adhered material presently on the underside of the lay up for further fastening downward. An example of such a lay up is a mastic or adhesive which shows through an optional lower expanded aluminium mesh layer.

Second layers of ABS or aluminium based materials impart to the layup structure a toughness which is remarkable over existing materials used for such applications. This toughness combined with the environmental resistance and UV resistance of the thermoplastic polyurethane first layer make a cladding material which is very useful for the present situation. The presence of aluminium or metal based materials or deformable plastics also renders the cladding membrane to be shaped whether hot or cold shaping occurs to a permanent or semi-permanent desired shape, for example when bending around architraves, or other building structures to retain at least initially its desired shape prior to fastening. The use of natural or manmade fibres imparts a light yet tough material which is also suitable for at least cladding systems as described herein. Of course the lamination of a thin first layer of thermoplastic polyurethane which is relatively expensive in comparison to other base materials such as ABS or the other mentioned plastics or metals allows a cost effective cladding membrane to be manufactured which is tough, yet cheap but which also has the required properties of weather and UV resistance whilst minimising the expensive material of the thermoplastic polyurethane. The lamination of this material with other base materials known in the art gives it further desirable properties.

With reference to Figures 1 through 26 there is shown the various components, layups and methodologies for constructing a cladding system in accordance with the present invention. The planar substrate 4 of the building such as ply wood or other cladding material is attached to a framing substrate 5 forming the skeleton and the planar substrate for framing the building substrate. The cladding membrane 6 together with fixing members and jointers forms the skin of the building

and may be laid on vertical, horizontal or other surfaces as required. Of course in some situations where no load is to be taken either the framing substrate 5 or the planar substrate 4 may be omitted provided there is at least some form of substrate which the cladding membrane 6 can be applied to.

As referred to herein the terms building envelope, building substrate, building substructure mean the underlying framing or planer substrate of the building to which the cladding membrane 6 is attached to, unless specified otherwise.

Once the building substrate (either planar or framing) has been constructed then the cladding membrane may be applied. Two situations arise and these are whether the fixing members are to lie under the cladding membrane and thus against the building substrate or lie above the cladding membrane 6 and thus lie on top of the cladding membrane. A feature common to both types of fixing member is penetrative fastenings which allow the attachment or fastening of the fixing member to the building substrate. Alternatively there may be for the fastenings which lie against the building substrate another method of attachment such as adhesive or other means of adhering. The fixing members usually consist of a more rigid core such as that of a plastics or metal material about which is substantially coated a fusible weldable material such as thermoplastic polyurethane which is fusibly weldable by application of ultrasonic energy or thermal energy. The fixing member may also be purely of thermoplastic polyurethane rather than an over coating of a cone. For discrete fastenings such as those shown in Figures 1 through 4 there is a singular location for a penetrative fastening in this case in the centre of the discrete fixing. The upper surface 9 of the discrete fastenings 8 can also be sealed over to present a continuous sealed face. This becomes obviously advantageous when the discrete fixings of Figures 1 and 2 are used on the outer surface or upper surface of the cladding membrane.

The discrete fixings used for under surface fixing of the cladding membrane such as those shown in Figures 3 and 4 need not have such sealing over of the penetrative fastener on the upper surface 9 but may of course have this if so desired. The common characteristic of fixing members which lie on the upper surface of the cladding membrane is that their under surface 10 has at least a layer of fusibly

weldable materials such as a thermoplastic polyurethane so that when the fastener is in place it may be fusibly welded by ultrasonic or thermal or other means to the upper surface of the cladding membrane which also has a fusibly weldable material such as a thermoplastic polyurethane. A common characteristic of those fastenings which lie under the cladding membrane such as the discrete fastenings of Figures 3 and 4 is that the upper surface 9 has at least a layer of thermally fusible material such as a thermoplastic polyurethane which may be fusibly welded to a like under surface of the cladding membrane once it is laid over the top.

For both fixing members and jointers or joining components, or any area where fusible welding is to occur there may be optionally additionally protrusions 34 to direct the welding energy and provide a fusible region. These may take form of teeth, rounded bumps, concentric rings etc and may lie over the entire or only part of the member, membrane or jointer.

A join may also be effected by layering above and/or below the cladding membrane a layer(s) of cladding membrane which are then fused together to create a join. Lap joins of abutting overlapping sheets are also envisaged.

Further embodiments of fixing members are shown in Figure 11 which is an extrusion preferably with a stiff core and an outer coating at least of a fusibly weldable material which has a cap 13 collected by an upright 14 which in this case also has a penetrative fastening passing therethrough to form a lateral cavity 15 which allows the jointing of cladding membranes 6 to form a sealed join once at least the cap has been fusibly welded to the cladding membranes 6. The penetrative fastenings of such a fixing member may be as shown staggered diagonally across the width of the fixing member or may be disposed purely to one or other sides or purely in the middle. Means to form purely a sealing or join of two abutting sheets of cladding membrane take the form of either a flat strip which may be laid down over the join and then fusibly welded thereto or may be similar to that shown in Figures 5 and 7 whereby a tee jointer 21 may be laid over the join and the upright of the tee 22 lie in a space between the two membranes and the arms 16 of the tee lie over the upper surface of

the cladding membranes to be joined. Thereafter fusible welding forms a permanent seal and join between the two cladding membranes and the jointer 21.

A contour strip jointer 18 which is similar to that shown in Figures 5 and 7 of a T jointer is shown in Figure 6 with provision for a penetrative fastening location 17 to allow the jointer 18 once laid over the two adjoining membranes to not only be fusibly welded to these membranes but also to fasten the membranes down by penetrative fastening. An engageable cap 19 may be disposed in a complimentary region 20 and may perform a seal mechanically or may form the seal by fusible welding. A similar T joint to that of Figures 6 and 7 is shown in Figure 8 with the exception that this is an invert tee which is fastened or fastenable to the building substrate and thereafter the cladding materials laid overtop with an upright ridge 23 running the length of the join and the cladding membrane being fusibly welded to the jointer to form a weather proof and element proof join. Again fastenings or fastening locations 7 are available for fixing the jointer to the building substrate prior to the cladding membranes being laid and sealed thereto.

Continuous strapping fixing members such as that shown in Figure 19 and 20 are also envisaged. The strap 24 shown in Figure 19 has at least an underside surface 10 which has a layer of thermally fusible material which when laid over the top of the cladding membrane can be fused thereto and with the penetrative fastenings 7 passing through the strap 24 and the membrane and through into the building substrate will fasten the cladding membrane down. A further sealing membrane may be laid over the top of the strap 24 extending either side of the strap which then may also be fusibly welded down to either the strap or the cladding membrane to form a sealed fixing. Alternatively some form of mastic or silicon or similar may be used to fill in the fastening holes.

Figure 20 shows a strap similar to that of Figure 19 as 25 however this strap is designed to lie under the cladding membrane and thus will be fastened first via fasteners 7 into the building substrate and thereafter the cladding membrane is laid overtop of the strap 25 and then fusibly welded down by application of ultrasonic energy or thermal energy to permanently fuse the cladding membrane down to the

strap. Of course in both embodiments 24 and 25 those surfaces to be fusibly welded have a suitable material that can be fusibly welded to the cladding membrane.

In corners consisting of two or three surfaces there exists the problem of sealing the join, if present, of the cladding membrane and also or additionally fastening that location to the building substrate. Shown in Figures 12 and 13 is one method of fastening the membrane down by having an overtop fastening member 26 laid into the, in this case, three surface corner which has penetrative fastening 7 to pass through the cladding membrane 6 and into the building substrate which is then fusibly welded to the upper surface of the cladding membrane 6. The overtop fastening member 26 having on its underside a thermally fusible material, and likewise the upper surface of the cladding membrane 6 has similar fusible material. Figure 13 shows a similar system to that of Figure 12 however the fastening member 27 lies under the cladding membranes 6 and has penetrative fastenings which are applied on or through the fastening 27 into the building substrate thereafter the cladding membrane 6 is laid over the top and the fastening member 27 is fusibly welded to the underside of the cladding membrane. Again surfaces to be thermally fused have thermally fusible materials present thereon. Corner pieces consisting of two or more surfaces at an angle to each other are shown in Figures 14 and 15. These, as do previous joinings or fastening members, have a rigid core to which is over applied a layer of fusibly weldable material. The three surface jointer 28 has penetrative fastenings in or on thereto and lies on the upper surface of the cladding membrane 6 and is fastened into place and thereafter fusibly welded to the cladding material. At the lower portion 29 of the three surface jointer may be fastened down either by penetrative fastenings and or fusibly weldable fastenings to a substrate or a strap fixing member 25 to hold the lower surface 29 in place. Additionally the cladding membrane may lie overtop of lower surface 29 and be fusibly welded thereto. Likewise in Figure 15 a similar surface jointer is shown which is penetratively fastened to the building substrate lies over the top of the cladding membrane 6 and is fusibly welded thereto. An alternative embodiment to those of Figures 14 and 15 is shown in that of Figure 16 whereby the surface jointer 30 lies underneath the cladding material 6 is penetratively fastened to

the building substrate and thereafter the cladding material 6 is fusibly welded to the surface jointer 30. The internal (inwards) corner pieces shown in Figures 12 through 16 can also be used on external (outwards) corners and ridges to seal and fasten and join, where penetrative fastenings are used these are reversed in direction to enable penetrative fastening. For example of this the corner inward overlap fastening member 26 may be used on an external corner in an overtop fashion but with fasteners 7 in the opposite direction. Members may further be flexible or rigid. Further embodiments of jointers are shown in Figures 17 and 18 for angled corners and tee joints. In Figures 21 through 25 are shown further embodiments of corner sealers. A sloping three surface jointer 31 is shown of a rigid variety (i.e. having a rigid core or base overlaid therewith a fusibly weldable material such as thermoplastic polyurethane) which is locatable in a matching corner over the top of or underneath of cladding membranes to be corner sealed. The sealing being achieved by fusibly weldable means such as ultrasonic welding or thermal welding. It is to be understood that those portions to be fusibly welded have like matching fusibly weldable materials. Variations of a cone corner jointer both rigid and flexible are shown having differing angles or focus points to allow for varying shaped corners. The flexible and/or rigid corner is pushed into location at the corner to be joined or sealed and deformed into the corner to be sealed or joined (likewise for a ridge or external corner). The cone corner jointers may lie under or over the cladding membrane to be joined and a range of focus points or angles are available to fit the corner to be jointed as required.

A further embodiment of the three surface jointer of 31 as shown in Figure 23 as 32 and may again be rigid or flexible to under or overly the cladding material to be sealed or joined. The surface jointer being attached to the cladding membrane and sealing it by the application of energy to fusibly weld materials together.

Shown in Figure 26 is also a flashing cap 33 which has a layer of fusibly weldable material such as thermoplastic polyurethane on at least its outer an preferably its inner surfaces for fusible welding to a cladding membrane 6 to hold the cladding membrane in place and also seal thereto and also to hold the flashing cap 33 in place.

For any of the external or over surface fixing members described herein a further sealing member may be applied over the top such as a circle for those embodiments in Figures 1 or square for Figure 2 or whatever shape is required to extend past the periphery of the fixing member which can then be fusibly welded to the cladding membrane. Thus in a situation where the core of an over top fixing member is of metallic compound or compound that is not resistant to UV elements this fastening may nevertheless be rendered environmentally resistant and further sealed, particularly when the penetrative fastening shows through the top of the fixing member.

Various patterns may be used to achieve the fusible welding via ultrasonic or thermal means such as concentric circles or stippling of such a close nature that an impenetrable seal is formed particularly for external over top fixing and sealing members. These welding patterns may be matched to the form of protrusions 34 at the welding site. In a situation where an over top fixing member is used and the penetrative fastening is left bear the underside of the penetrative fastening may have applied thereto a fusibly weldable material which will mate with a fusibly weldable material on the upper surface of the fixing member such that when ultrasonic or thermal energy is applied to that region a seal is formed between the penetrative fastener and the fixing member thus forming another way of creating a sealed fixing member. As referred to herein a fusibly weldable material that is exposed to the environment is of a thermoplastic polyurethane preferably. For underside or non exposed areas which require a fusibly weldable material either a thinner or cheaper layer of thermoplastic polyurethane may be used or other materials which are fusibly weldable may be used which are in themselves not necessarily UV stable or environmentally resistant as they are not exposed to the elements. In addition to the fastening methods detailed herein further retention of the cladding membrane to a building structure may be achieved by use of ballasted rooting methods whereby a stone or similar course is laid over the surface to retain by weight the cladding material onto the building structure. The cladding membrane may of course be applied to horizontal or vertical surfaces or the like and the fixing methods described herein will

achieve such result. In preparing such a cladding system for example in a roof, an array of fastening members is fixed down to the building substructure thereafter the cladding membrane is laid over the top jointers are located in place whether above or below and the resulting structure is sealed by ultrasonic or thermal welding at the regions of the fasteners and also the joins and also any corners. If over the top fixing members are to be used then the cladding membrane is laid down over the building substructure the fixing members are penetratively fastened down through the cladding membrane to the building substructure and thereafter fusibly welded by ultrasonic or thermal and the jointers are laid down in place and thereafter the jointers and fixing members are fusibly welded to the cladding membrane to form a sealed weather proof structure.

The fixing members, jointers, and joining members and corners may be formed by extrusion, co-extrusion, lamination, over coating, moulding, moulding and over coating or other combination of these and other methods, known in the art. The cladding membrane likewise may be manufactured by extrusion, co-extrusion, lamination, moulding or coating or combination of these techniques and others known in the art.

The flashing cap 33 may likewise be manufactured, for example by co-extrusion or extrusion and over coating with thermoplastic polyurethane to form a flashing or structural element for windows and roofs with at least an external over coating of thermoplastic polyurethane. The base extrusion may be polypropylene or polyethylene, or aluminium or other suitable rigid material.

TABLE 1

First Layer (Top) (A)	Second Layer (B)	Third Layer (Bottom) (C)	Laminar/Encapsulated
TPU 0.01mm – 1.5mm	ABS 0.001mm – 2.5mm	-	Laminar
		TPU 0.01mm – 2.5mm	Laminar or Encapsulated
		ABS 0.01mm – 2.5mm	Laminar or Encapsulated
	Aluminium Foil 0.001mm – 2.5mm	ABS/TPU/PP/PE/EPDM/ EVA 0.01mm – 2.5mm	Laminar or Encapsulated

	Aluminium Mesh 0.001mm – 2.5mm	ABS/TPU/PP/PE/EPDM/ EVA 0.01mm – 2.5mm	Laminar or Encapsulated
	Polypropylene 0.001mm – 2.5mm	ABS/TPU/PP/PE/EPDM/ EVA 0.01mm – 2.5mm	Laminar or Encapsulated
	Polyethylene 0.001mm – 2.5mm	ABS/TPU/PP/PE/EPDM/ EVA 0.01mm – 2.5mm	Laminar or Encapsulated
	Natural Fibre (e.g. jute, cotton) 0.001mm – 2.5mm	ABS/TPU/PP/PE/EPDM/ EVA/TPR/PET 0.01mm – 2.5mm	Laminar or Encapsulated
	Man-made Fibre (e.g. PP, PET, PE) 0.001mm – 2.5mm	ABS/TPU/PP/PE/EPDM/ EVA/TPR/PET 0.01mm – 2.5mm	Laminar or Encapsulated

Intellectual Property
Office of NZ

16 OCT 2003
RECEIVED

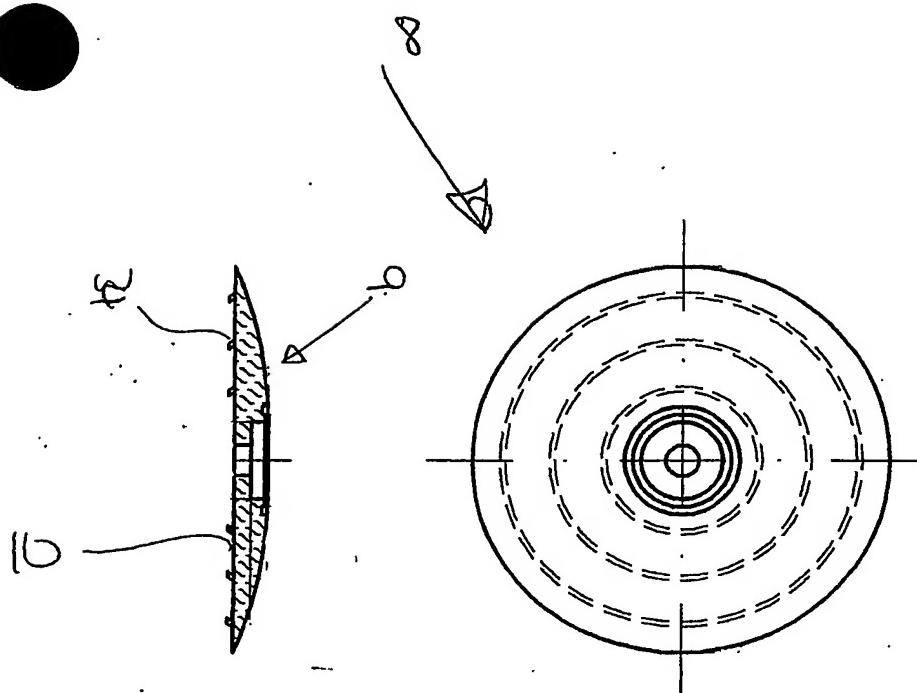


FIGURE 1

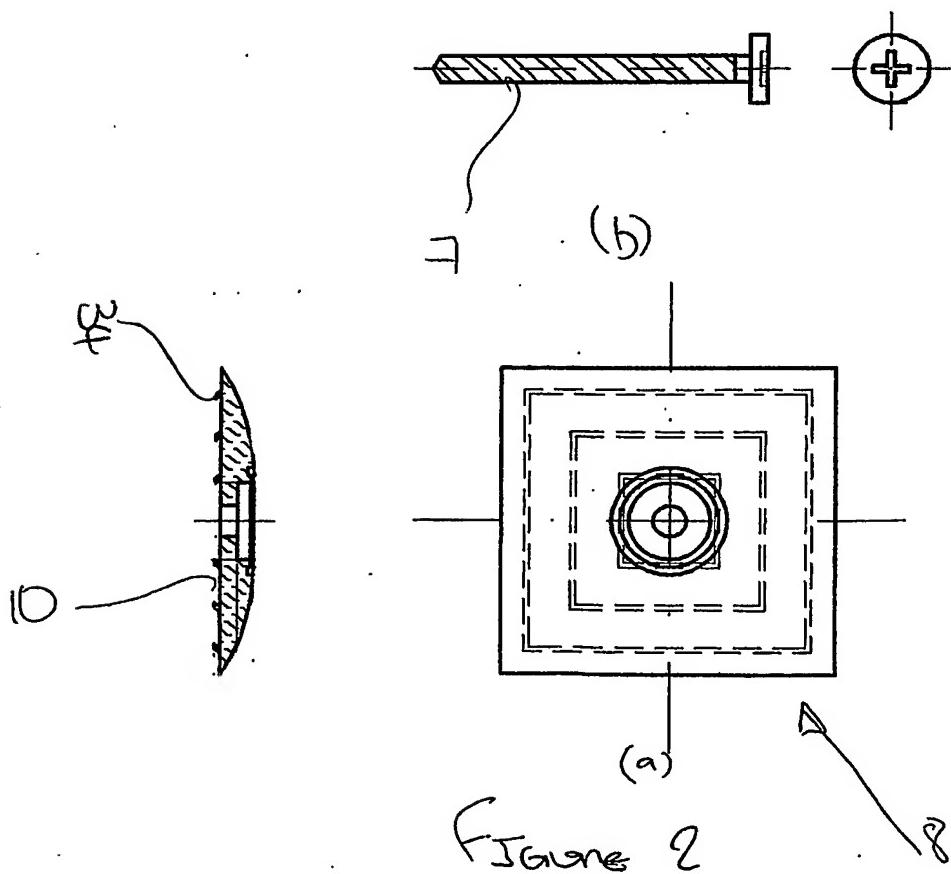


FIGURE 2

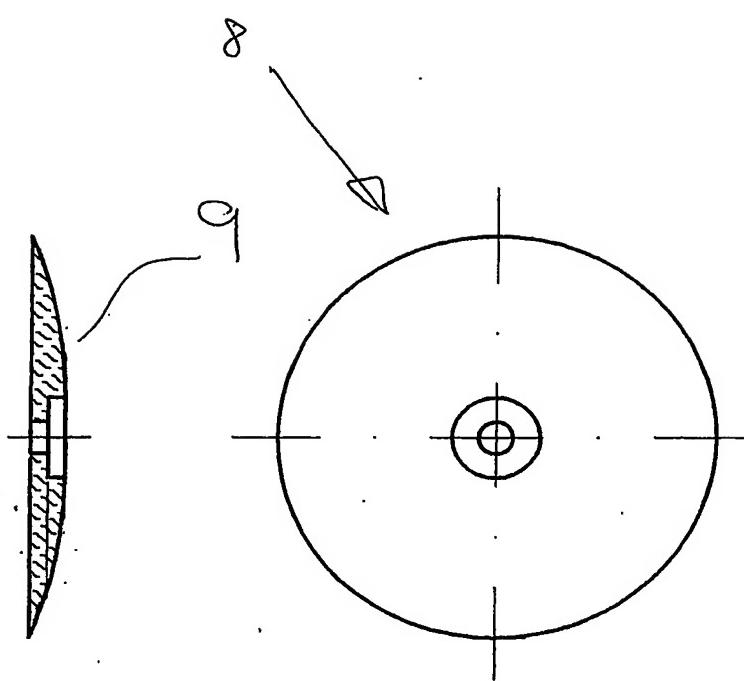
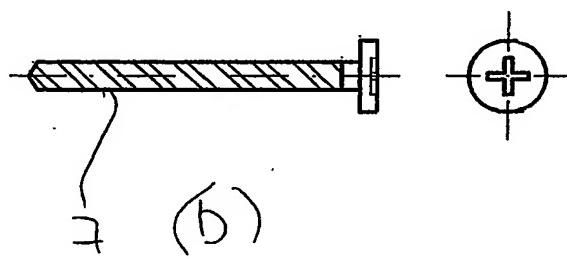
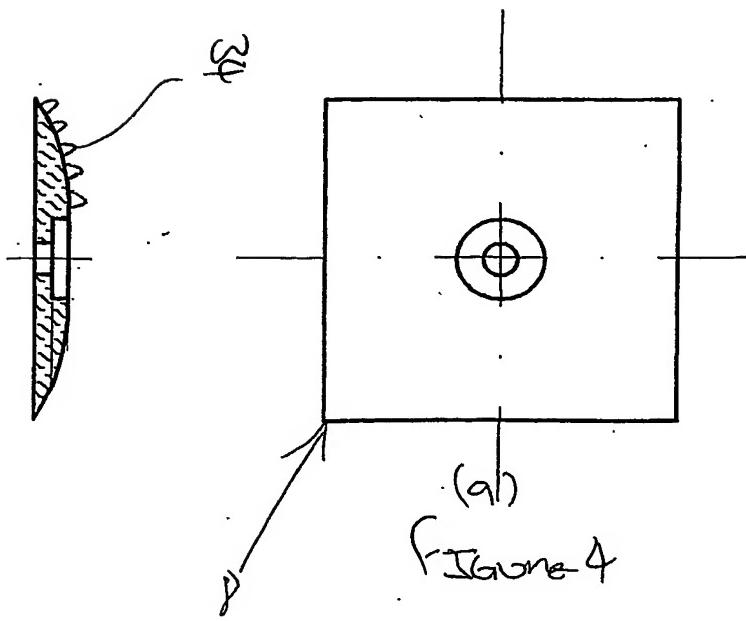


FIGURE 3



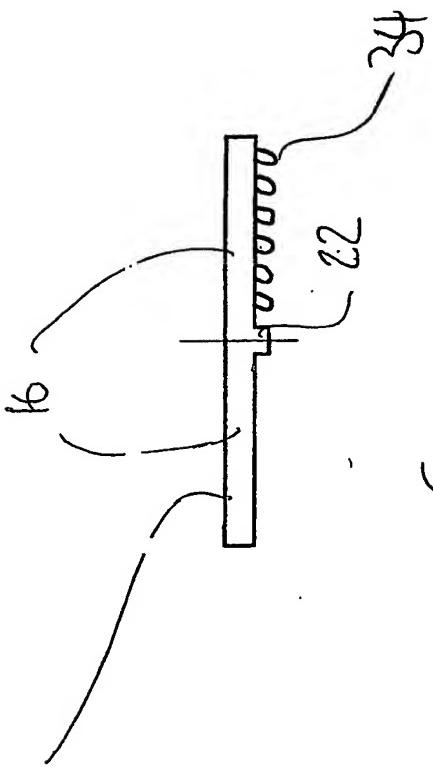
(b)



(a)

FIGURE 4

Figure 5



21

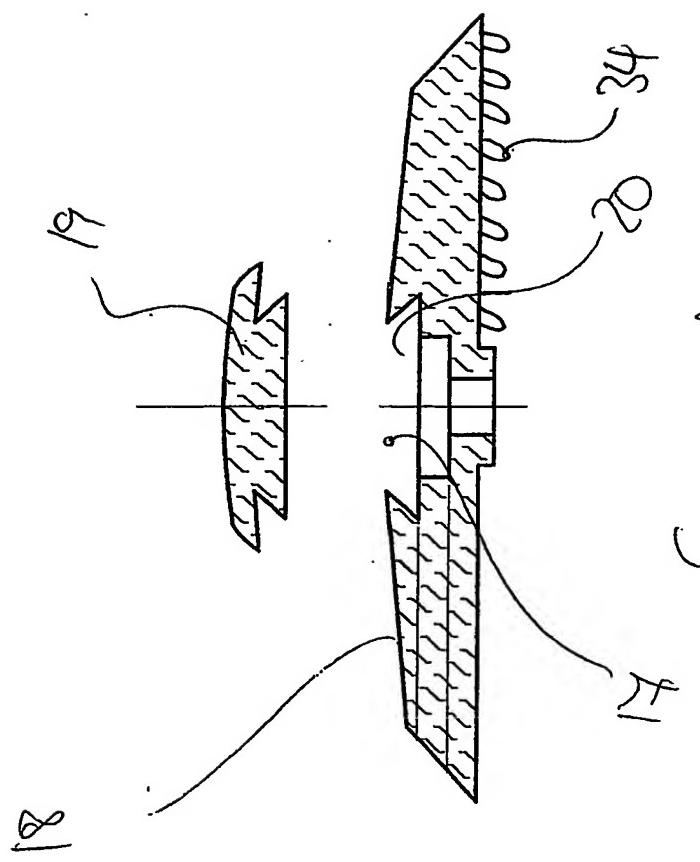
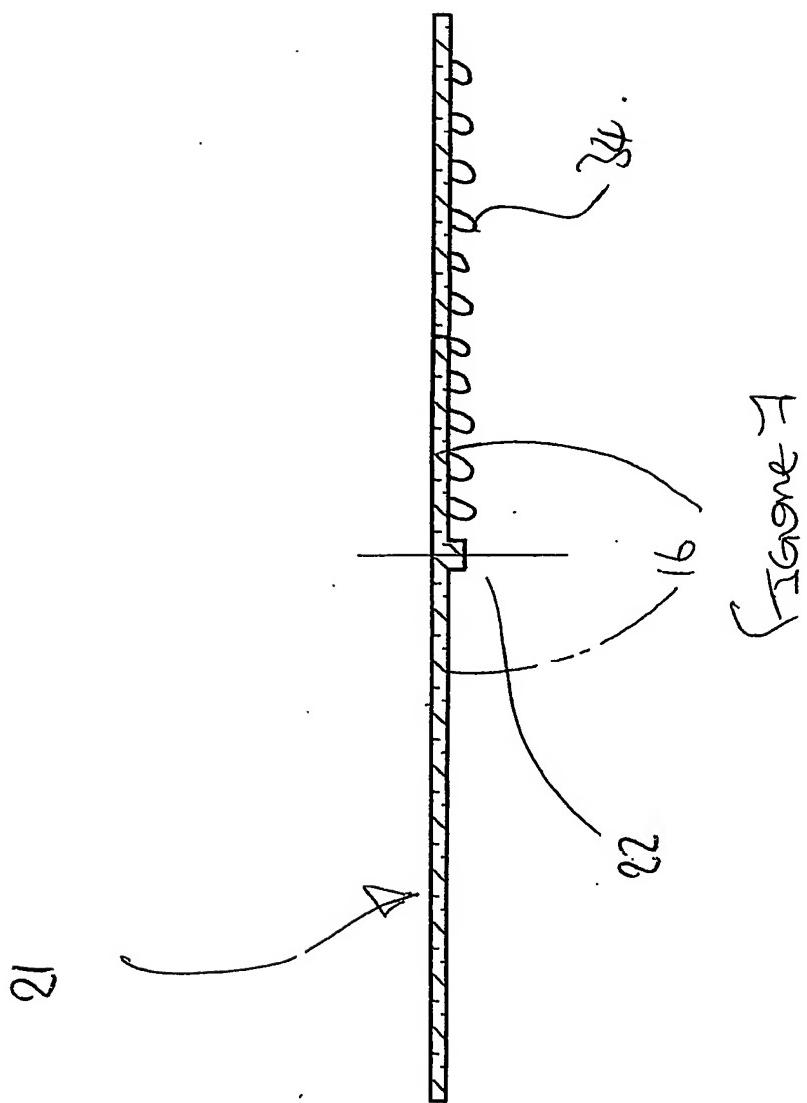
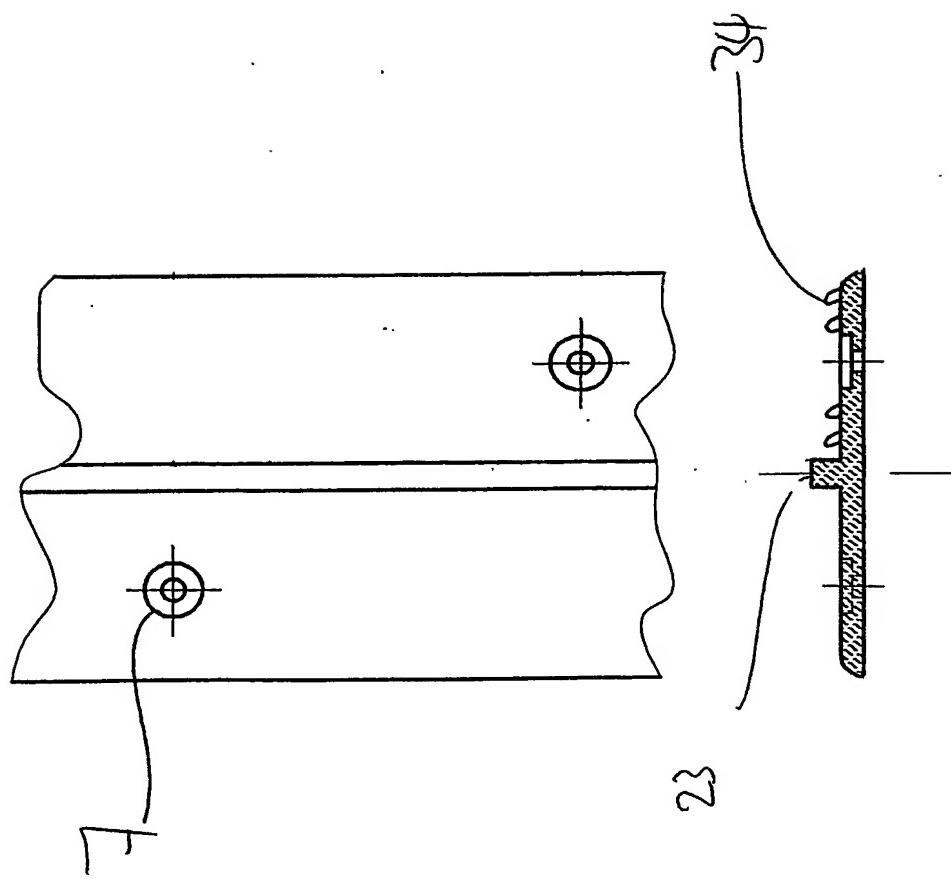


Figure 6





Ignore 8

Figure 9

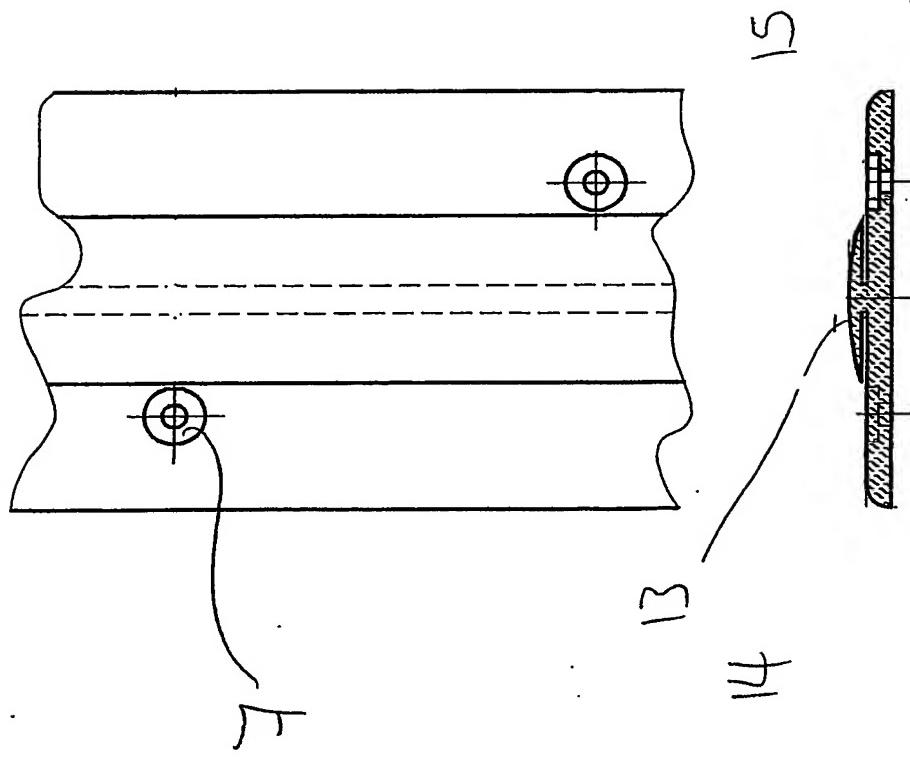
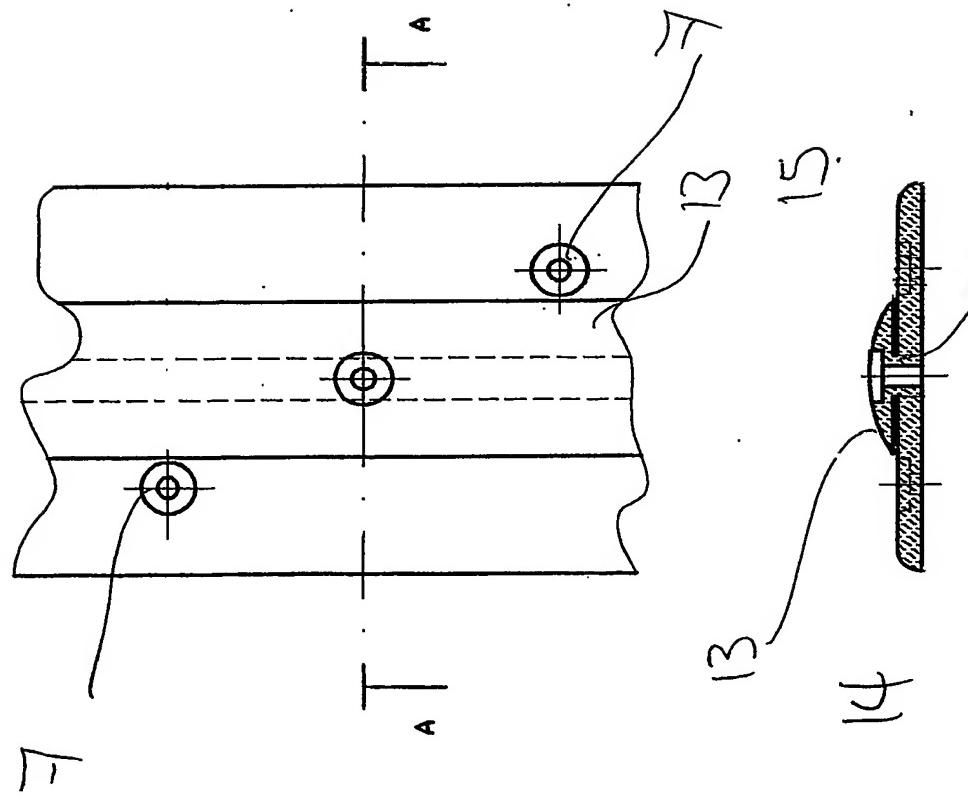


Figura 10



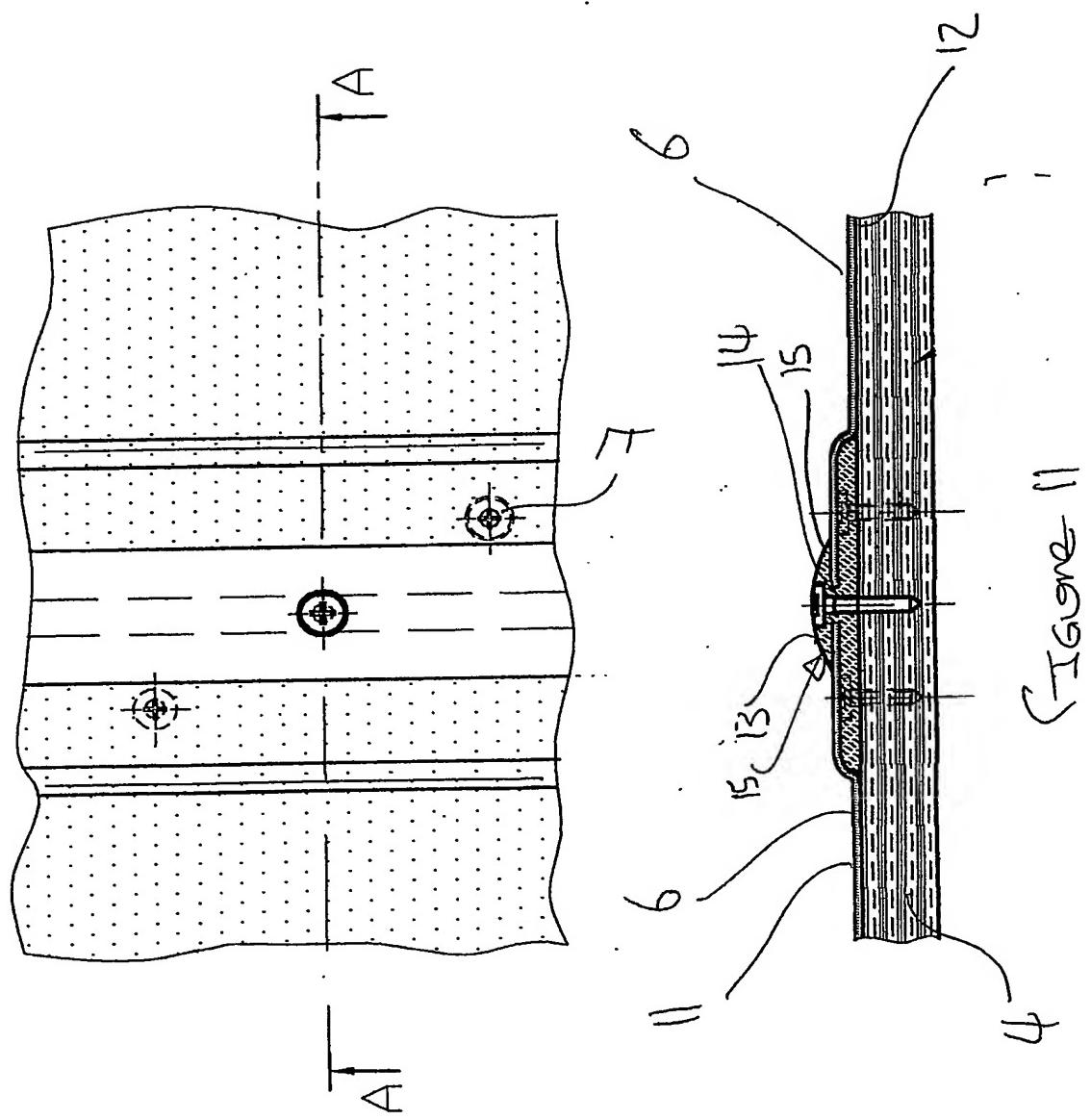
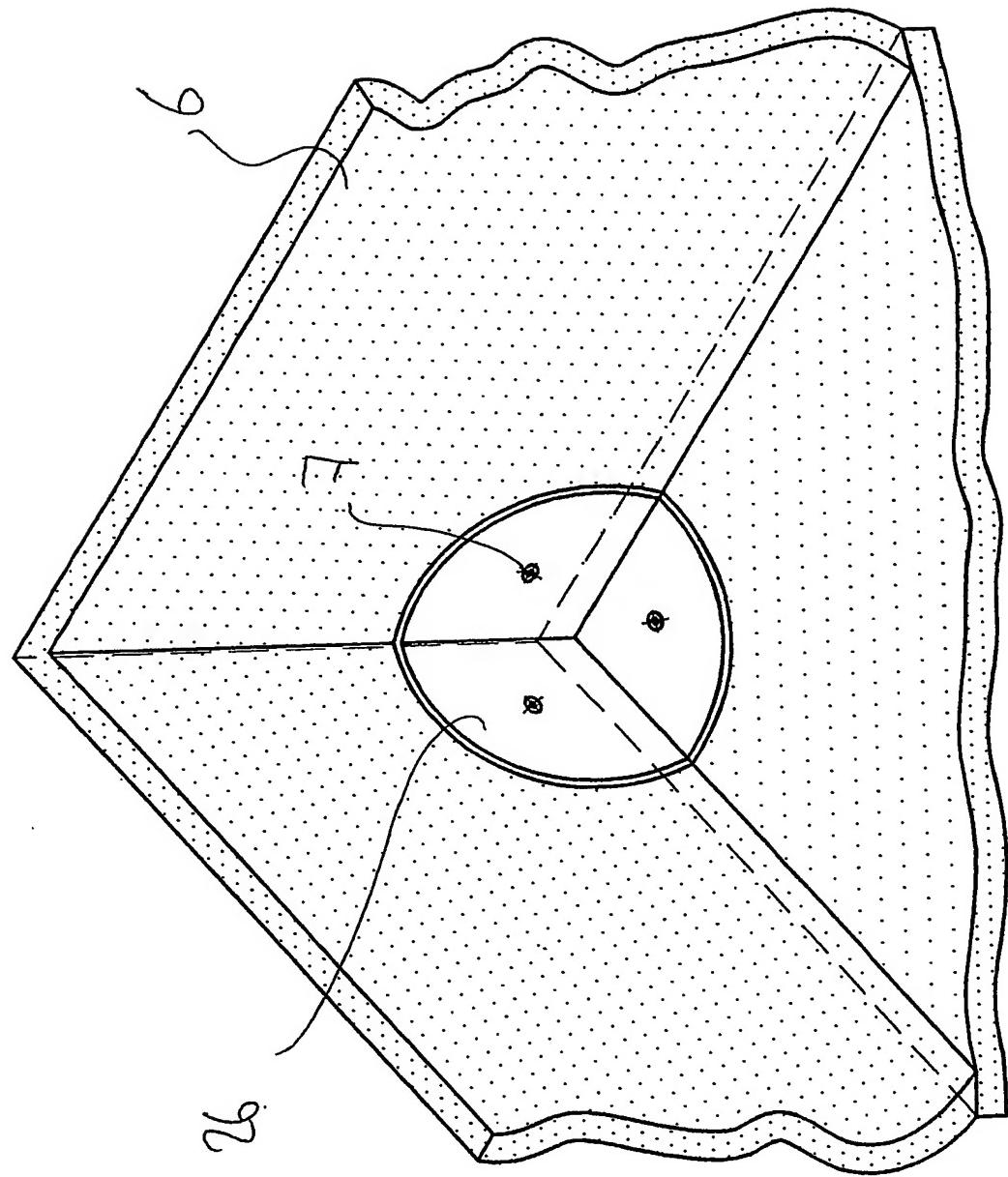


Figure 11

Figure 12



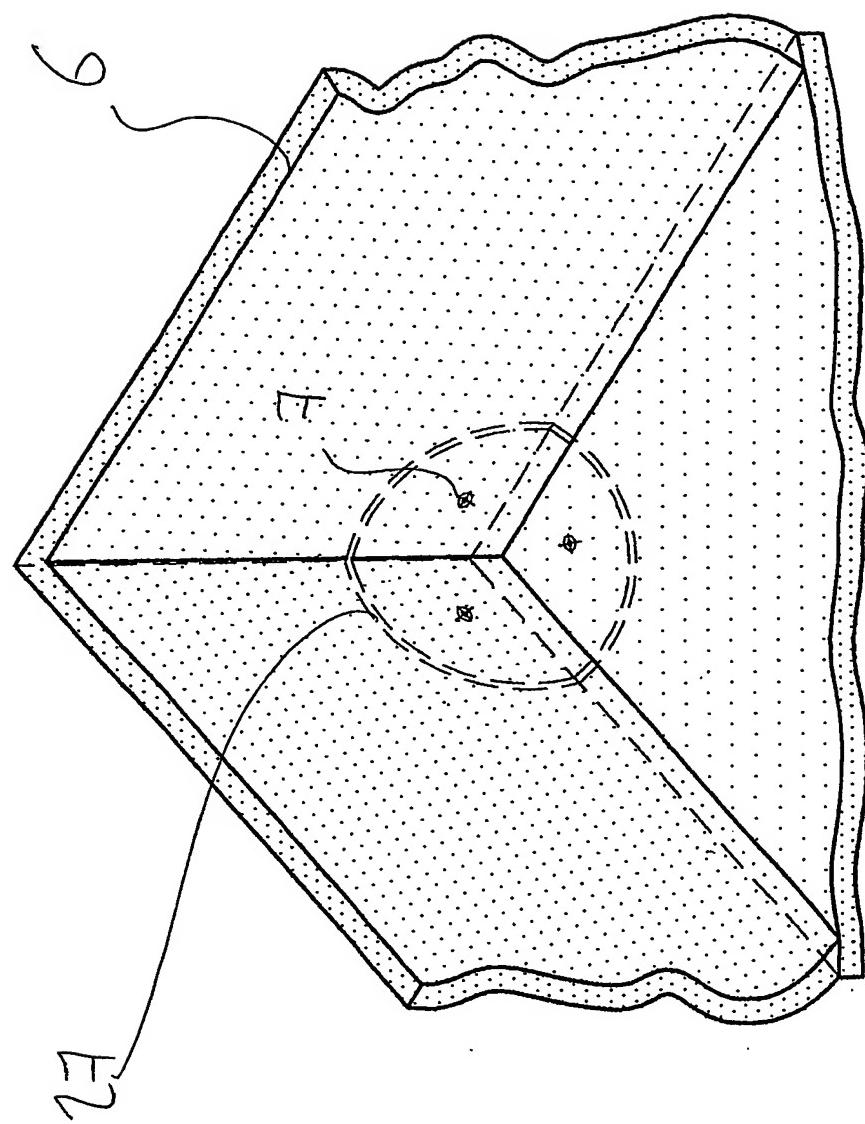


Figure 13

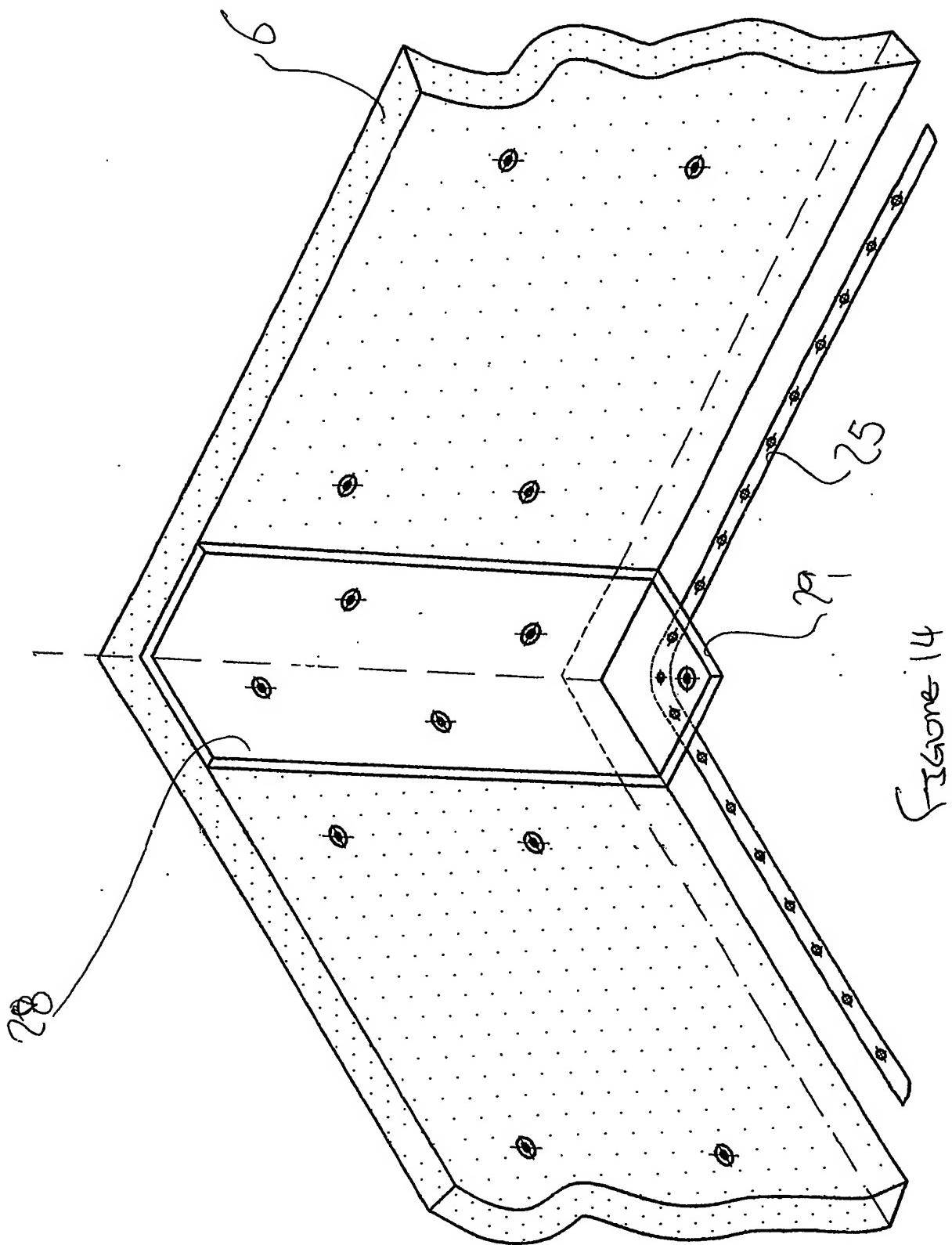


Figure 14

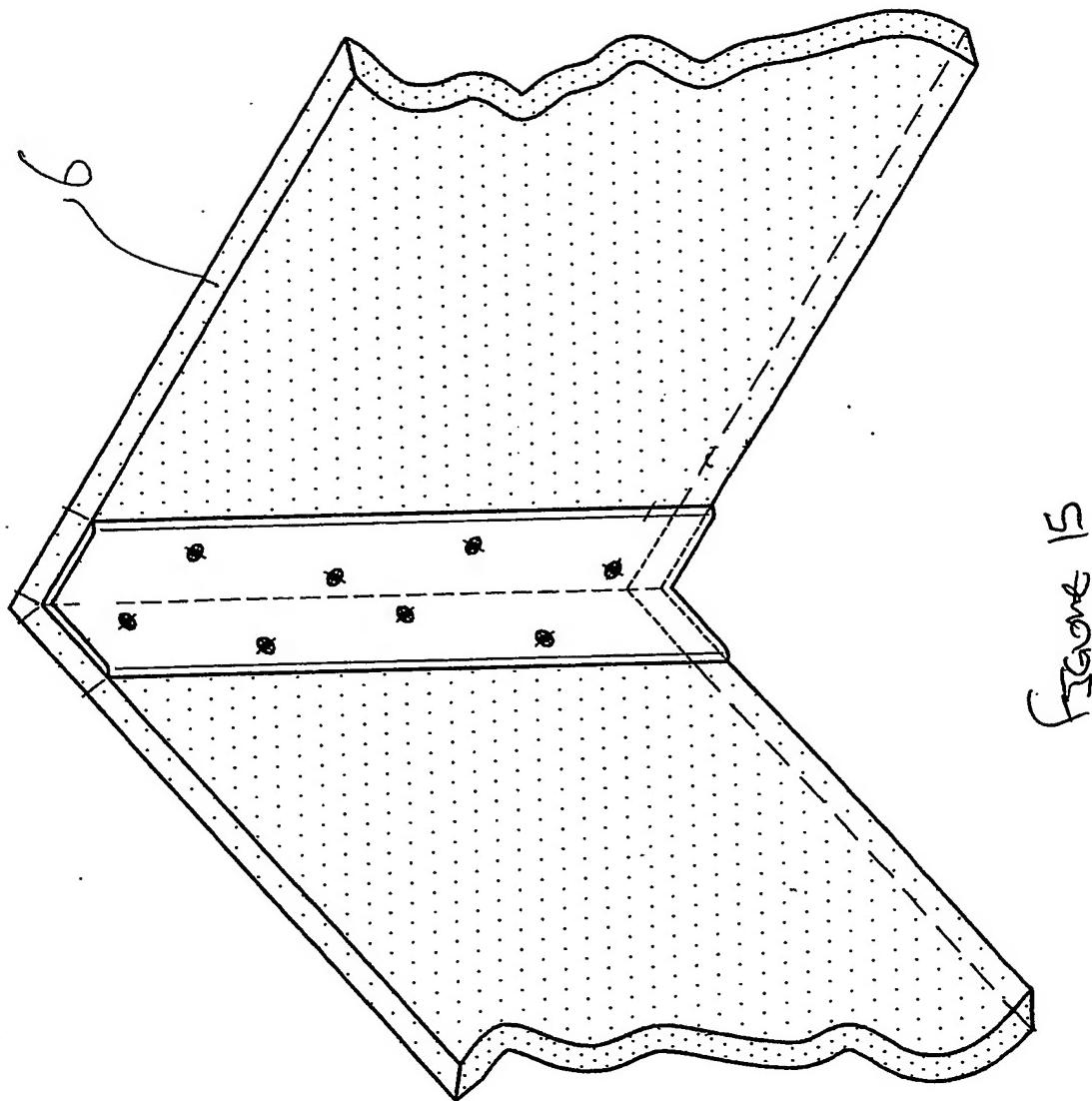


Figure 15

ROOFTIGHT CORNER FIXIT - "U"/90

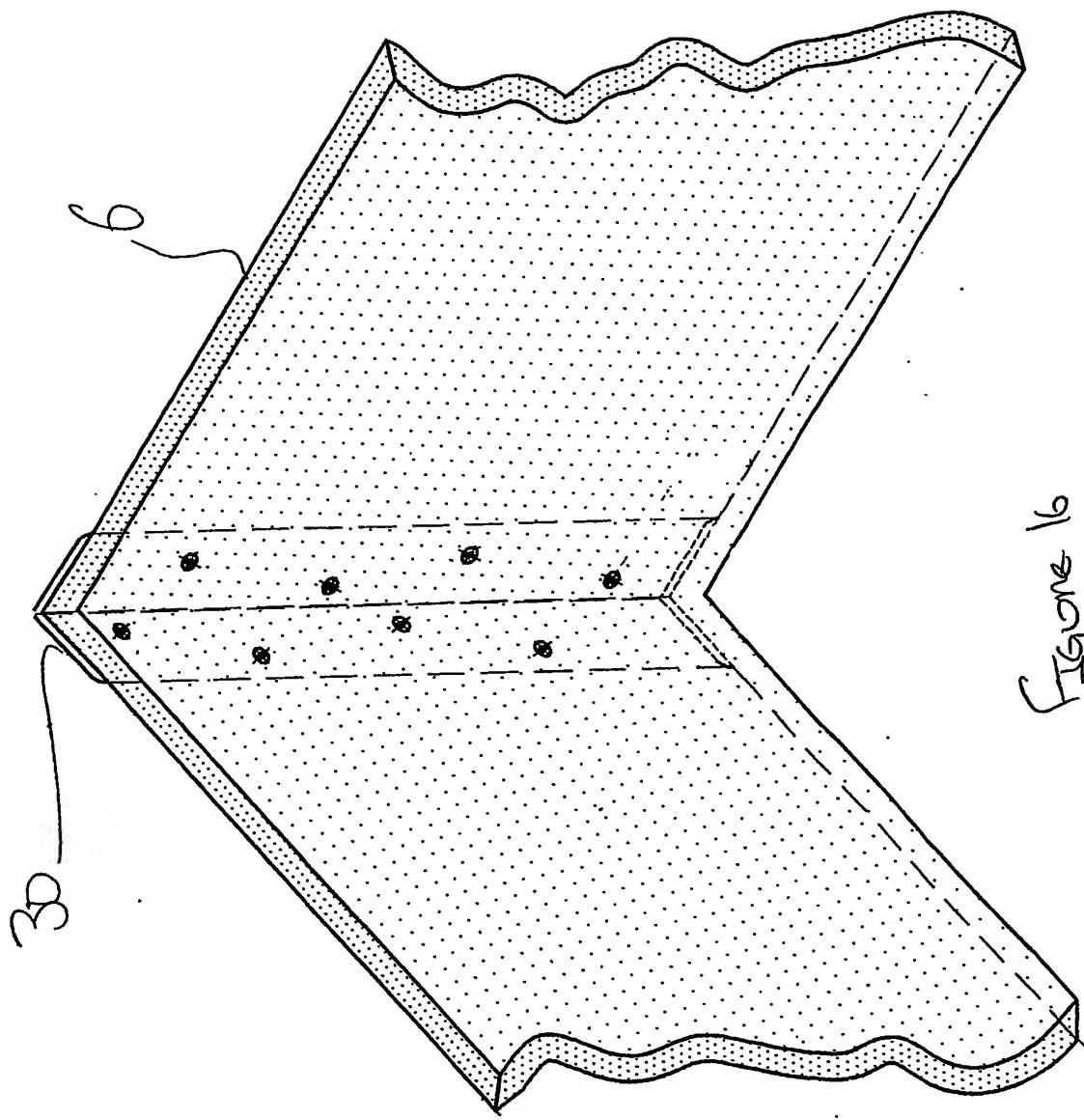
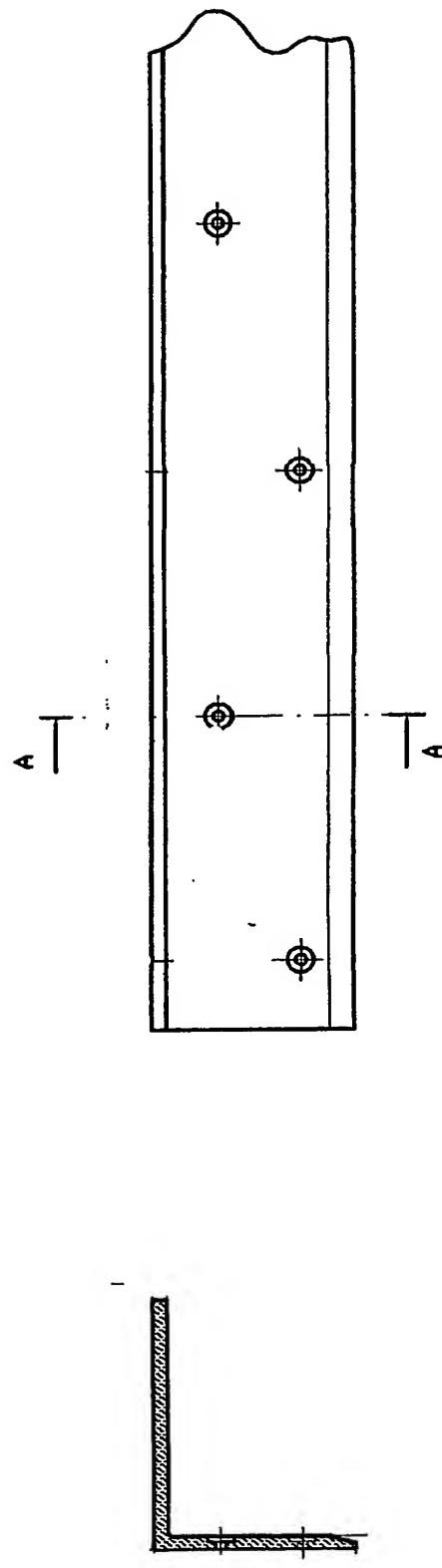


Figure 16

Figure 17



SECTION A-A

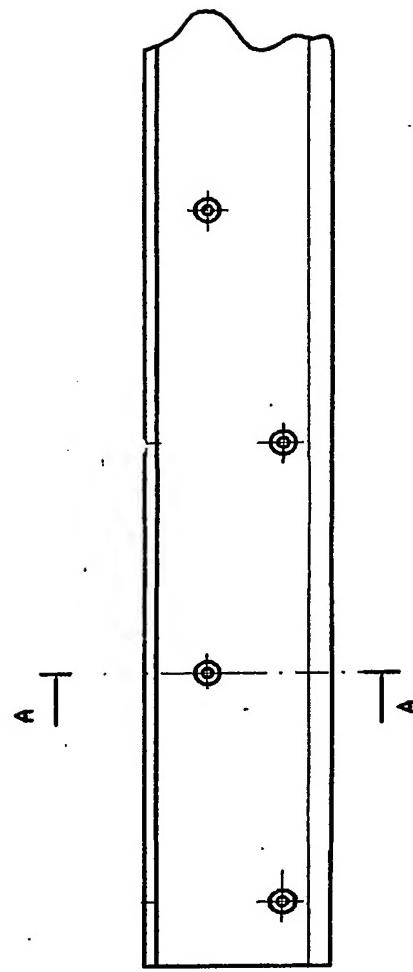
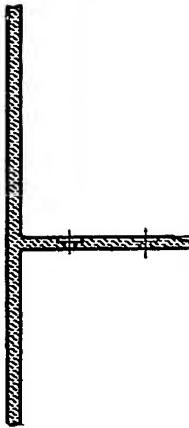


Figure 18

SECTION A-A



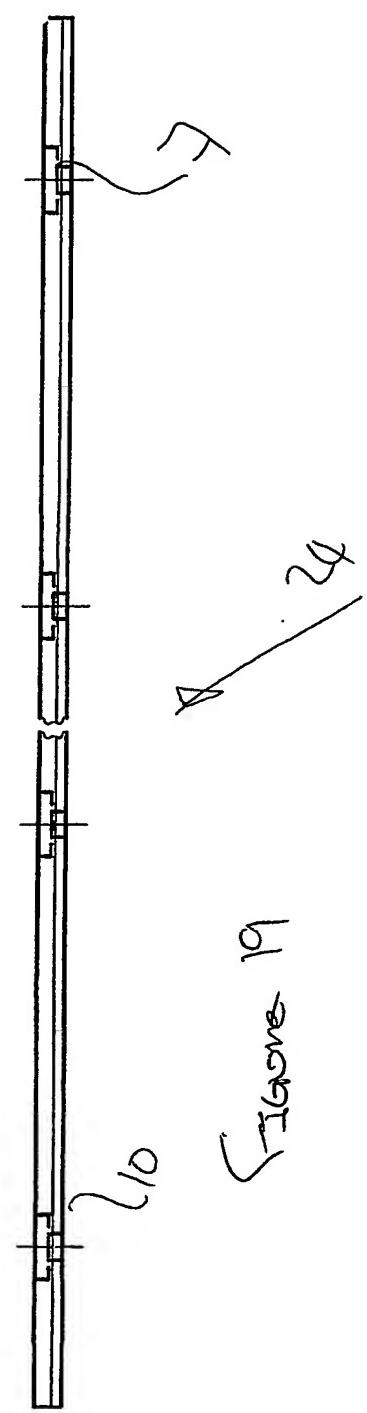
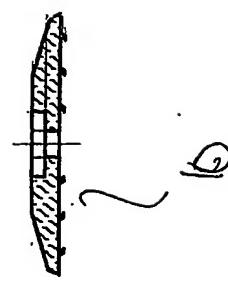


Figure 19



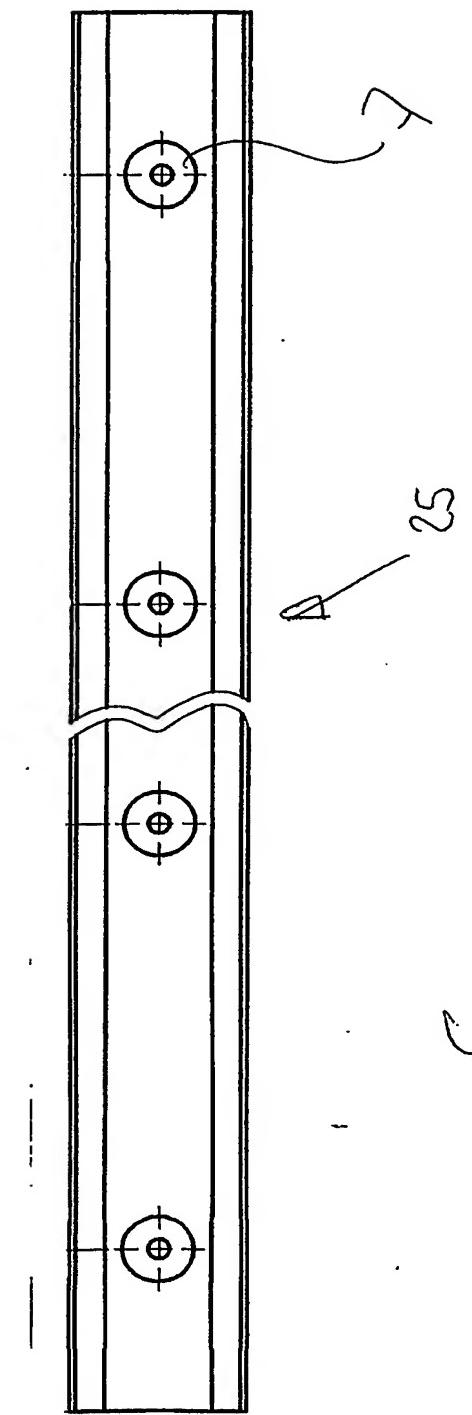
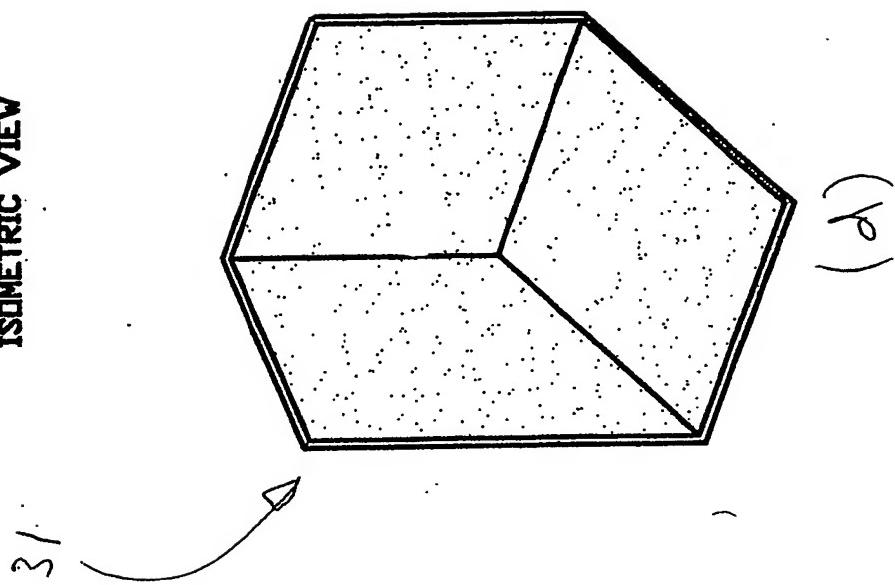


Figure 20

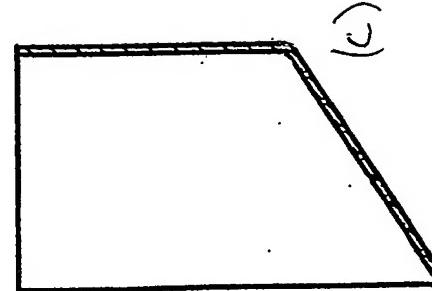
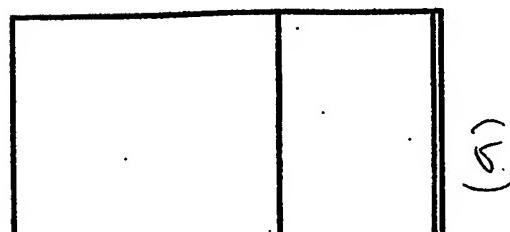
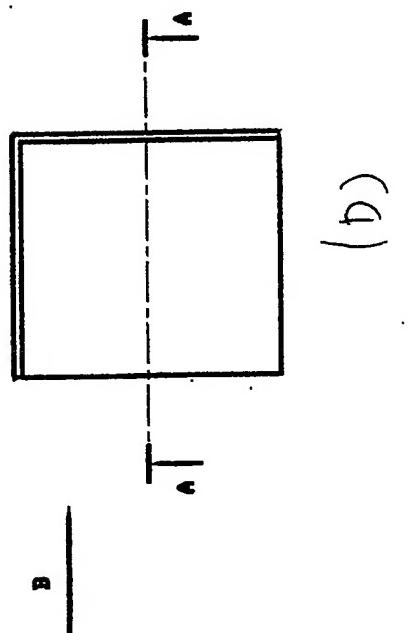


Figure 21

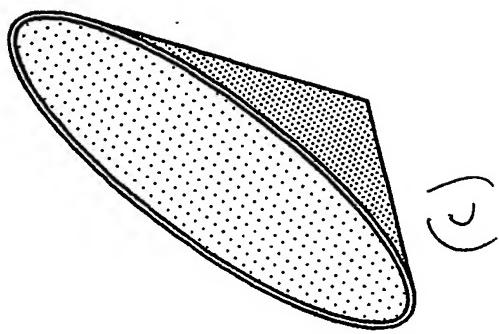
ISOMETRIC VIEW



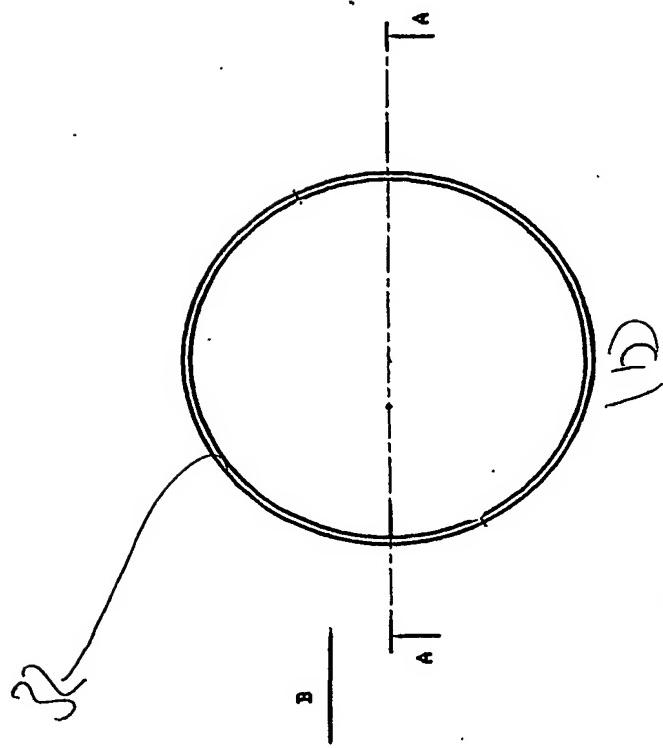
VIEW B



ISOMETRIC VIEW

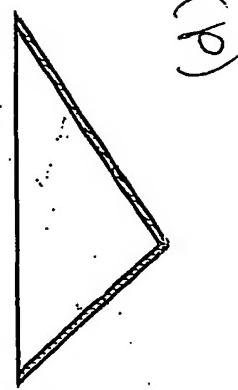


(c)



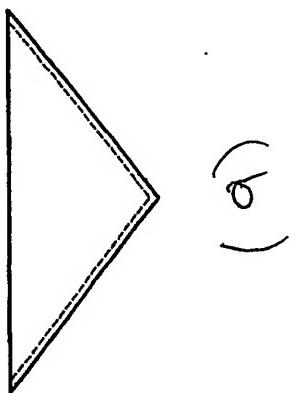
(d)

SECTION A-A



(d)

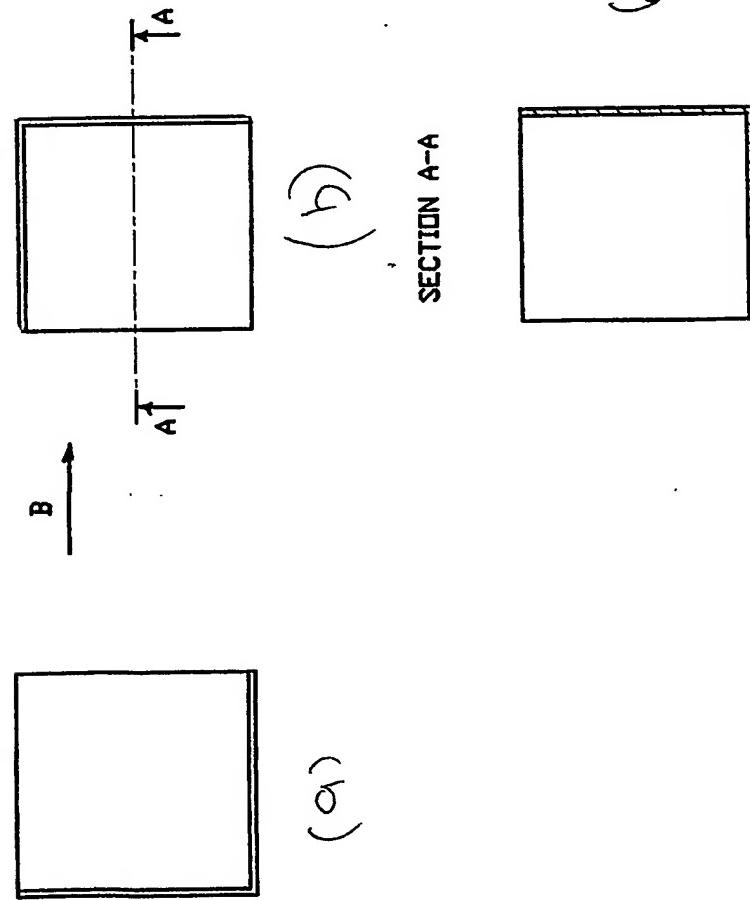
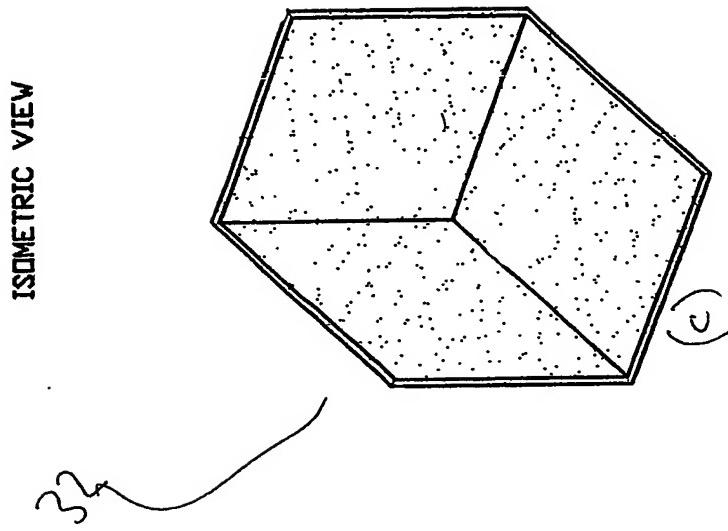
VIEW B



(a)

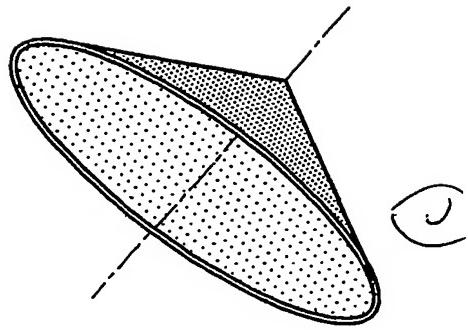
Figure 22

Figure 23

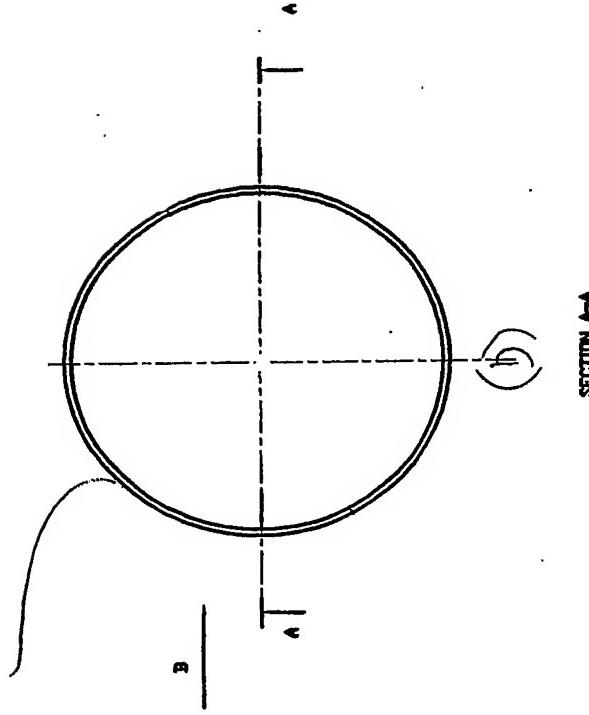


32

ISOMETRIC VIEW

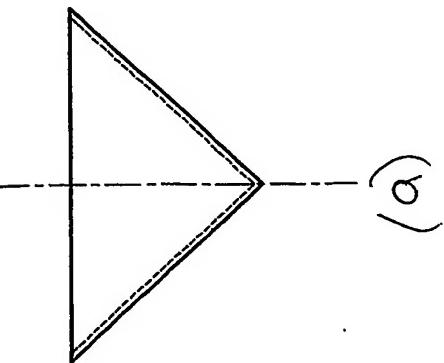


(c)



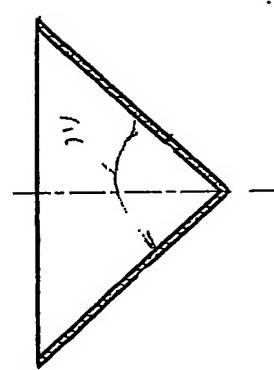
(d)

VIEW 3



(a)

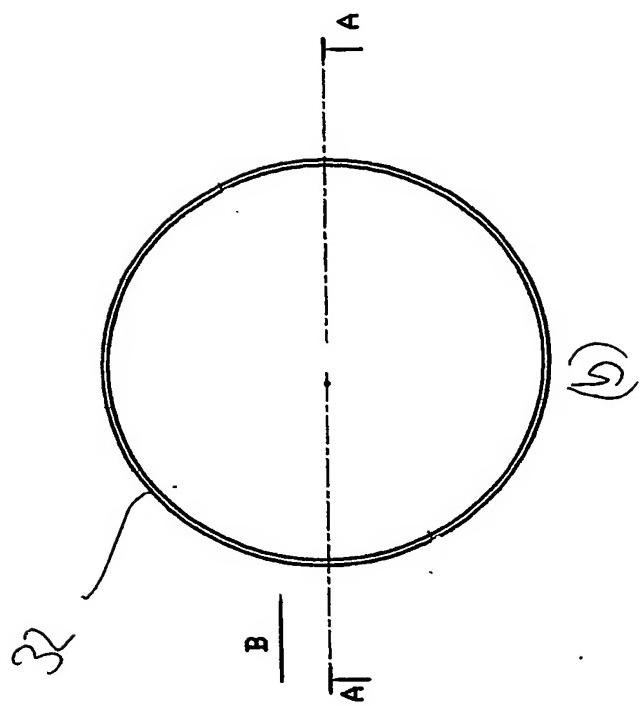
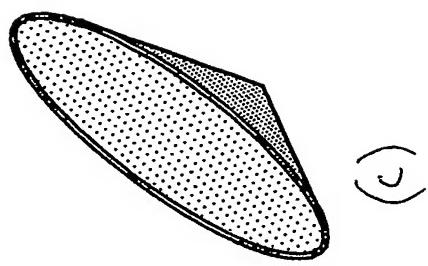
SECTION A-A



(d)

Figure 24

ISOMETRIC VIEW



SECTION A-A

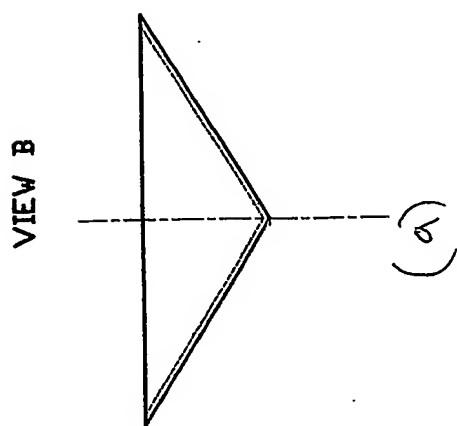
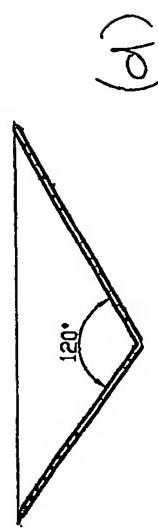


Figure 25

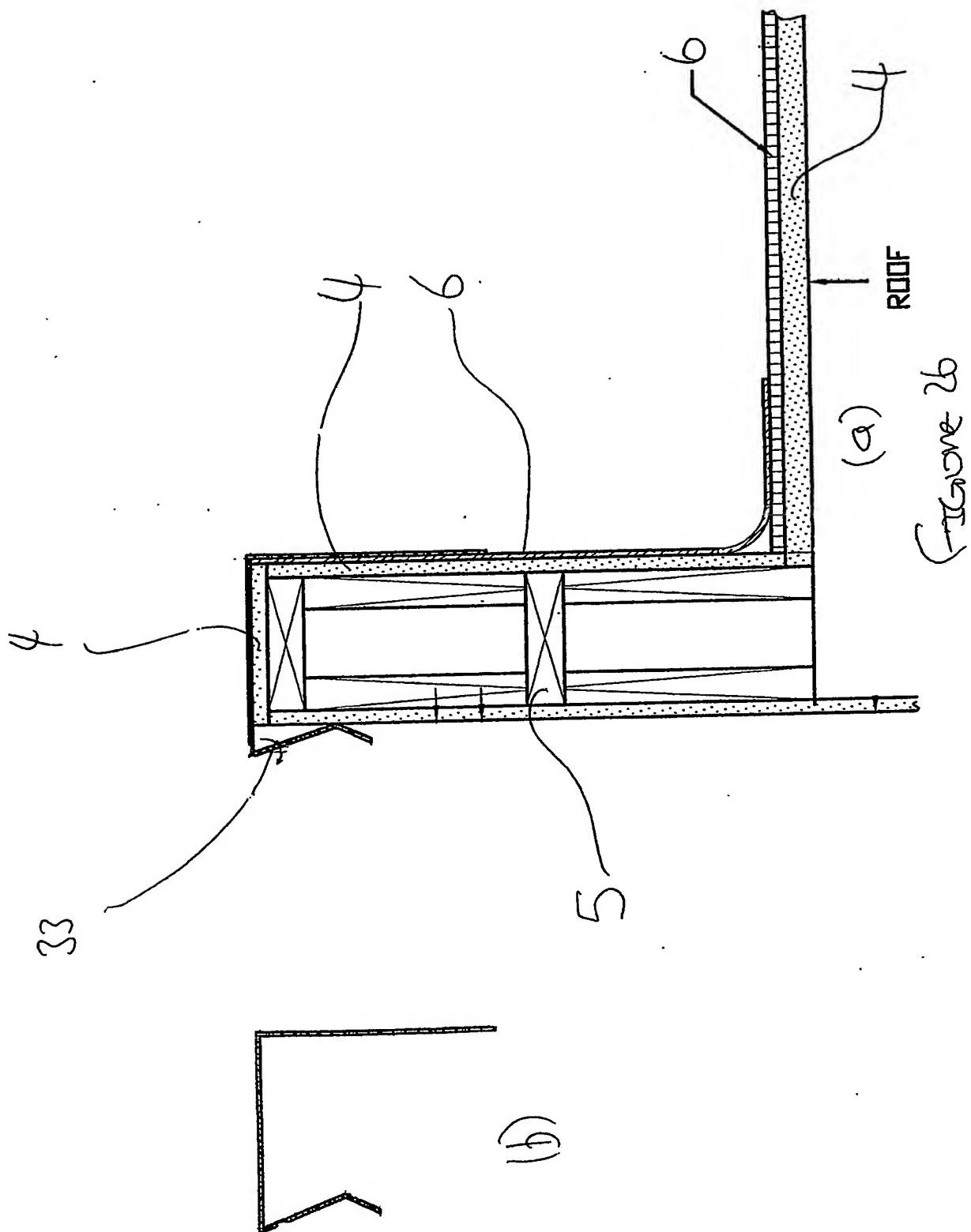


Figure 26

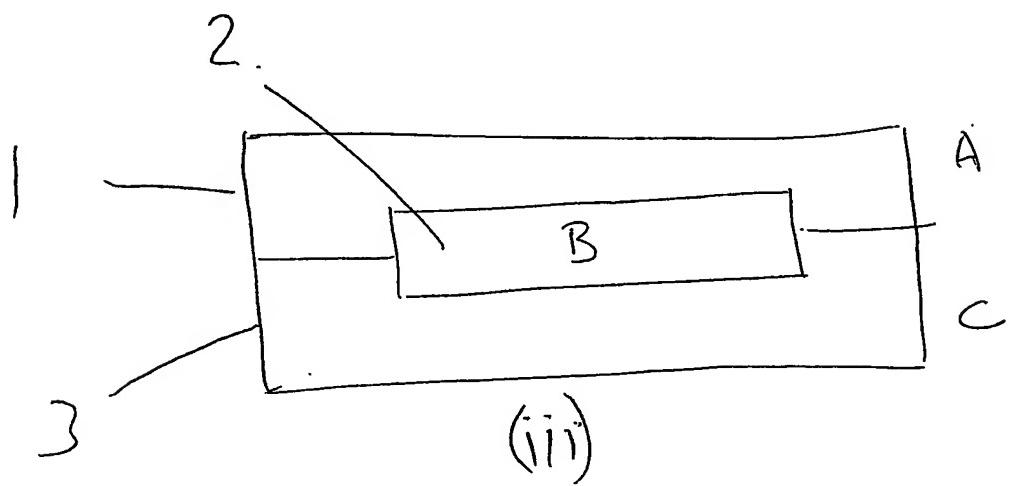
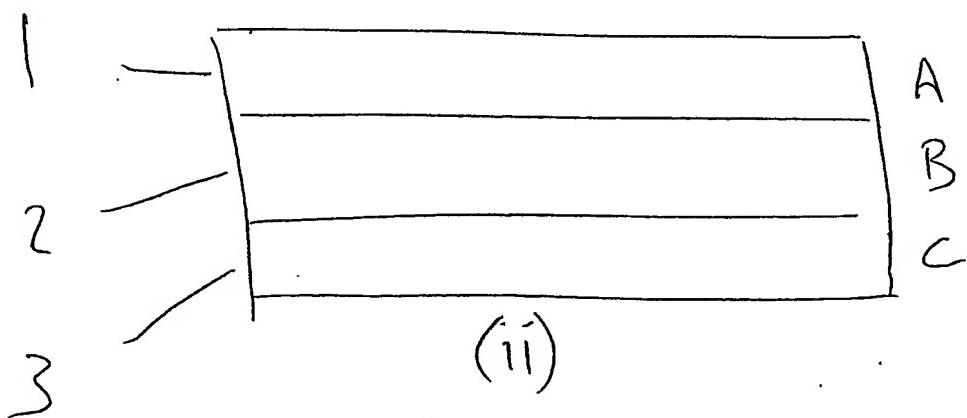
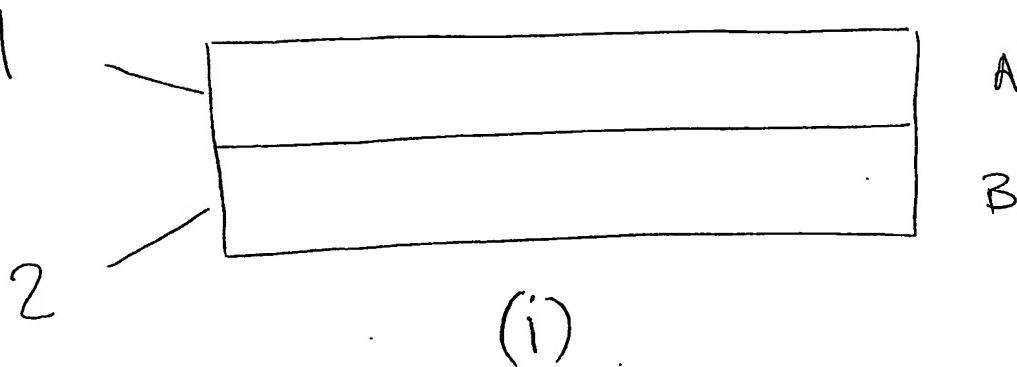


FIGURE 27

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- BLACK BORDERS**
- IMAGE CUT OFF AT TOP, BOTTOM OR SIDES**
- FADED TEXT OR DRAWING**
- BLURRED OR ILLEGIBLE TEXT OR DRAWING**
- SKEWED/SLANTED IMAGES**
- COLOR OR BLACK AND WHITE PHOTOGRAPHS**
- GRAY SCALE DOCUMENTS**
- LINES OR MARKS ON ORIGINAL DOCUMENT**
- REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY**
- OTHER:** _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.